



US009199055B2

(12) **United States Patent**
Galbraith et al.

(10) **Patent No.:** **US 9,199,055 B2**
(45) **Date of Patent:** ***Dec. 1, 2015**

(54) **ULTRA RAPID CYCLE PORTABLE OXYGEN CONCENTRATOR**

(71) Applicant: **Separation Design Group LLC**,
Waynesburg, PA (US)

(72) Inventors: **Stephen Douglas Galbraith**, Holbrook,
PA (US); **Elise DePetrus**, Holbrook, PA
(US); **David K. Walker**, Waynesburg,
PA (US)

(73) Assignee: **Separation Design Group LLC**,
Waynesburg, PA (US)

(*) Notice: Subject to any disclaimer, the term of this
patent is extended or adjusted under 35
U.S.C. 154(b) by 0 days.

This patent is subject to a terminal dis-
claimer.

(21) Appl. No.: **14/519,868**

(22) Filed: **Oct. 21, 2014**

(65) **Prior Publication Data**

US 2015/0101603 A1 Apr. 16, 2015

Related U.S. Application Data

(63) Continuation of application No. 13/499,943, filed as
application No. PCT/US2010/051419 on Oct. 5, 2010,
now Pat. No. 8,894,751.

(60) Provisional application No. 61/264,069, filed on Nov.
24, 2009, provisional application No. 61/248,712,
filed on Oct. 5, 2009.

(51) **Int. Cl.**

B01D 53/02 (2006.01)

A61M 15/00 (2006.01)

(Continued)

(52) **U.S. Cl.**

CPC **A61M 16/101** (2014.02); **A61M 16/0003**
(2014.02); **A61M 16/0063** (2014.02);

(Continued)

(58) **Field of Classification Search**

CPC B01D 53/02; B01D 53/0415; B01D
53/0473; B01D 2253/108; B01D 2253/304;
B01D 2256/12; B01D 2257/102; B01D

2259/4541; Y10T 137/85938; A61M 16/0003;
A61M 16/0063; A61M 16/0672; A61M
16/1005; A61M 16/101; A61M 16/105;
A61M 16/20; A61M 2016/1025; A61M
2202/0208; A61M 2205/3327; A61M
2205/75; A61M 2205/8206

USPC 96/111, 121, 133, 147, 151; 95/130;
128/204.18, 205, 27

See application file for complete search history.

(56) **References Cited**

U.S. PATENT DOCUMENTS

3,952,239 A 4/1976 Owings et al. 320/113
5,288,306 A * 2/1994 Aibe et al. 95/141

(Continued)

FOREIGN PATENT DOCUMENTS

EP 2485794 10/2010
EP 10822515.2 10/2010

(Continued)

OTHER PUBLICATIONS

Supplemental European Search Report issued on Nov. 20, 2013 by
the European Patent Office for Application No. 10822515.2, which
was published as EP 2485794 on Sep. 3, 2012 (Inventor—Galbraith;
Applicant—Separation Design Group, LLC.) (6 pages).

(Continued)

Primary Examiner — Frank Lawrence

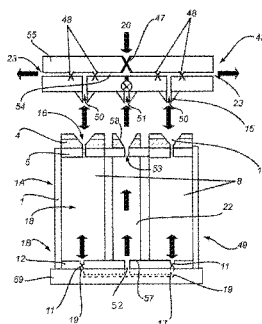
(74) *Attorney, Agent, or Firm* — Ballard Spahr LLP

(57)

ABSTRACT

Lightweight, portable oxygen concentrators that operate
using an ultra rapid, sub one second, adsorption cycle based
on advanced molecular sieve materials are disclosed. The
amount of sieve material utilized is a fraction of that used in
conventional portable devices. This dramatically reduces the
volume, weight, and cost of the device. Innovations in valve
configuration, moisture control, case and battery design, and
replaceable sieve module are described. Patients with breath-
ing disorders and others requiring medical oxygen are pro-
vided with a long lasting, low cost alternative to existing
portable oxygen supply devices.

21 Claims, 16 Drawing Sheets



(51) **Int. Cl.**

A61M 16/10 (2006.01)
B01D 53/04 (2006.01)
A61M 16/06 (2006.01)
A61M 16/00 (2006.01)
A61M 16/20 (2006.01)
B01D 53/047 (2006.01)

(52) **U.S. Cl.**

CPC **A61M16/0672** (2014.02); **A61M 16/105**
 (2013.01); **A61M 16/1005** (2014.02); **A61M**
16/20 (2013.01); **B01D 53/02** (2013.01); **B01D**
53/0415 (2013.01); **A61M 2016/1025**
 (2013.01); **A61M 2202/0208** (2013.01); **A61M**
2205/3327 (2013.01); **A61M 2205/75**
 (2013.01); **A61M 2205/8206** (2013.01); **B01D**
53/0473 (2013.01); **B01D 2253/108** (2013.01);
B01D 2253/304 (2013.01); **B01D 2256/12**
 (2013.01); **B01D 2257/102** (2013.01); **B01D**
2259/4541 (2013.01); **Y10T 137/85938**
 (2015.04)

(56)

References Cited

U.S. PATENT DOCUMENTS

6,515,451 B2 2/2003 Watson et al. 320/117
 6,592,731 B1 7/2003 Lawless 204/425
 7,204,249 B1 * 4/2007 Richey et al. 128/204.18
 7,273,051 B2 9/2007 Whitley et al. 128/205.11
 7,294,170 B2 11/2007 Richey, II et al. 95/8
 7,510,601 B2 * 3/2009 Whitley et al. 96/121
 7,763,103 B2 7/2010 Dolensky et al. 96/130
 7,828,878 B2 11/2010 Zhong et al. 95/96
 8,192,526 B2 6/2012 Zhong et al. 95/96
 8,377,181 B2 2/2013 Taylor et al. 96/121
 8,388,745 B1 3/2013 Pelletier et al. 96/108
 8,894,751 B2 * 11/2014 Galbraith et al. 96/111
 2002/0096174 A1 7/2002 Hill et al.
 2004/0107831 A1 6/2004 Graham et al. 95/96
 2005/0022815 A1 * 2/2005 Frola 128/204.21
 2005/0103341 A1 * 5/2005 Deane et al. 128/204.26
 2006/0137522 A1 6/2006 Nishimura et al. 95/96
 2006/0174874 A1 * 8/2006 Jagger et al. 128/201.21
 2006/0174881 A1 * 8/2006 Jagger et al. 128/201.25
 2006/0244417 A1 * 11/2006 Tsai et al. 320/112
 2007/0227360 A1 10/2007 Atlas et al.
 2009/0071333 A1 3/2009 LaBuda et al. 95/98
 2009/0145428 A1 6/2009 Sward et al. 128/202.26
 2010/0052293 A1 * 3/2010 Brooks et al. 280/651
 2012/0266883 A1 10/2012 Taylor et al. 128/205.12

FOREIGN PATENT DOCUMENTS

EP 2485794 8/2012
 FR 2851935 A1 9/2004
 FR 2916654 A1 12/2008
 GB 2013101 A 8/1979
 WO PCT/US2010/051419 10/2010
 WO WO 2011/044091 4/2011

OTHER PUBLICATIONS

International Search Report and Written Opinion mailed on Jun. 21, 2011 for PCT Application No. PCT/US2010/051419, which was published as WO 2011/044091 on Apr. 14, 2012 (Inventor—Galbraith Applicant—Separation Design Group, LLC.) (6 pages).
 International Preliminary Report on Patentability mailed on Apr. 11, 2012 for PCT Application No. PCT/US2010/051419, which was published as WO 2011/044091 on Apr. 14, 2012 (Inventor—Galbraith Applicant—Separation Design Group, LLC.) (6 pages).
 Amendment after Notice of Allowance submitted on Oct. 22, 2014 to the USPTO for U.S. Appl. No. 13/499,943, which was published as US 2012-0192864 on Aug. 2, 2012 (Inventor—Galbraith Applicant—Separation Design Group, LLC.) (6 pages).
 Notice of Allowance issued on Sep. 22, 2014 by the USPTO for U.S. Appl. No. 13/499,943, which was published as US 2012-0192864 on Aug. 2, 2012 (Inventor—Galbraith Applicant—Separation Design Group, LLC.) (10 pages).
 Amended Response to Restriction Requirement submitted on Aug. 27, 2014 to the USPTO for U.S. Appl. No. 13/499,943, which was published as US 2012-0192864 on Aug. 2, 2012 (Inventor—Galbraith Applicant—Separation Design Group, LLC.) (9 pages).
 Response to Restriction Requirement submitted on Aug. 22, 2014 to the USPTO for U.S. Appl. No. 13/499,943, which was published as US 2012-0192864 on Aug. 2, 2012 (Inventor—Galbraith Applicant—Separation Design Group, LLC.) (10 pages).
 Restriction Requirement issued on Jun. 24, 2014 by the USPTO for U.S. Appl. No. 13/499,943, which was published as US 2012-0192864 on Aug. 2, 2012 (Inventor—Galbraith Applicant—Separation Design Group, LLC.) (7 pages).
 U.S. Appl. No. 61/264,069, filed Nov. 24, 2009, Galbraith (Separation Design Group, LLC).
 U.S. Appl. No. 61/248,712, filed Oct. 5, 2009, Galbraith (Separation Design Group, LLC).
 U.S. Appl. No. 13/499,943, filed Oct. 5, 2009, Galbraith (Separation Design Group, LLC).
 U.S. Appl. No. 61/264,069, filed Nov. 24, 2009, Galbraith.
 U.S. Appl. No. 61/248,712, filed Oct. 5, 2009, Galbraith.
 U.S. Appl. No. 13/499,943, filed Apr. 3, 2012, Galbraith.

* cited by examiner

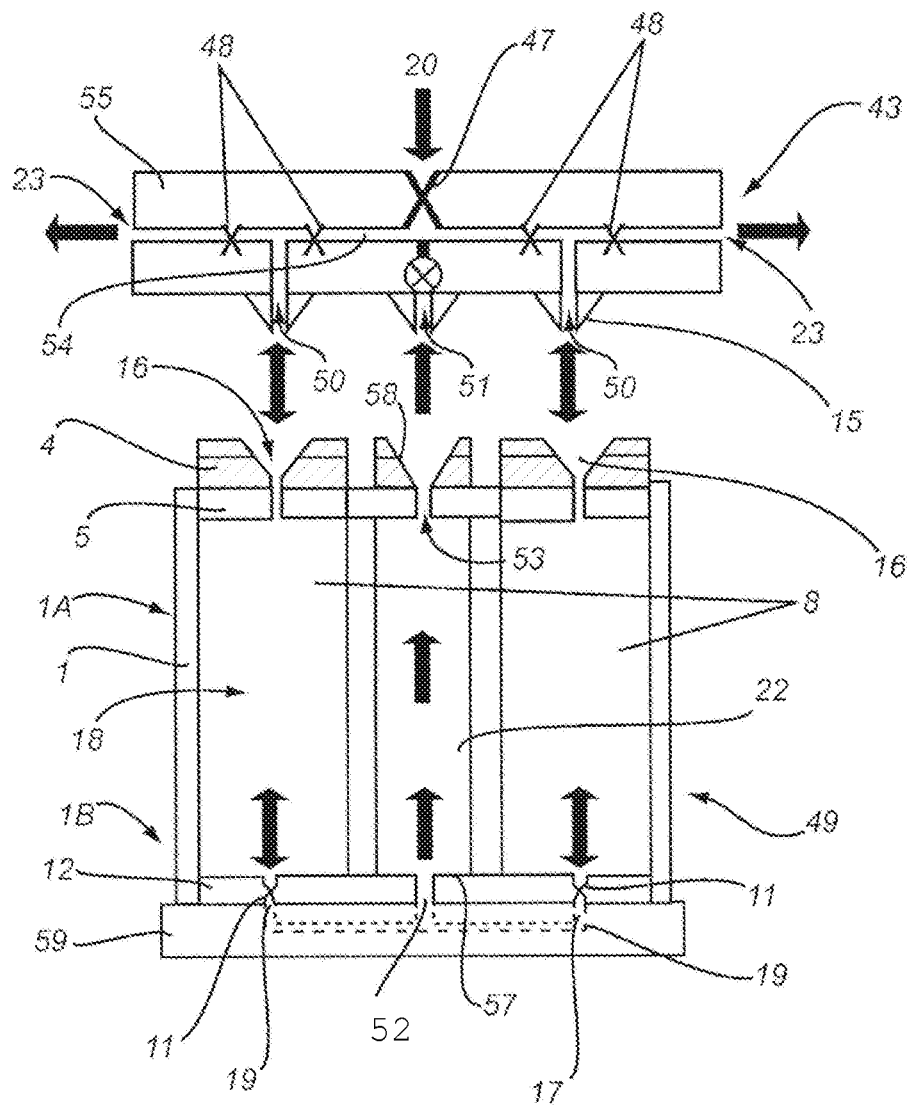


Figure 1

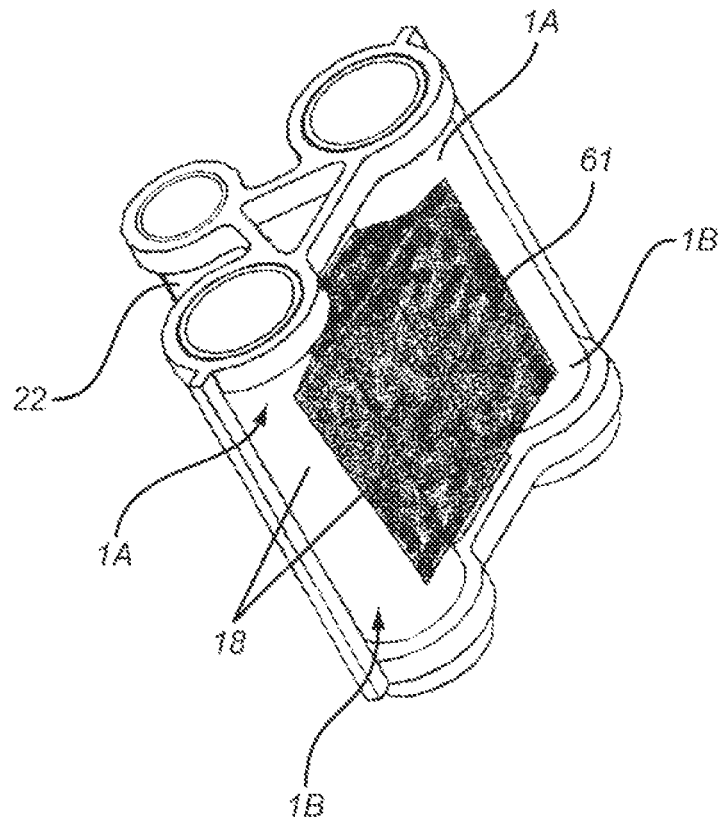


Figure 1A

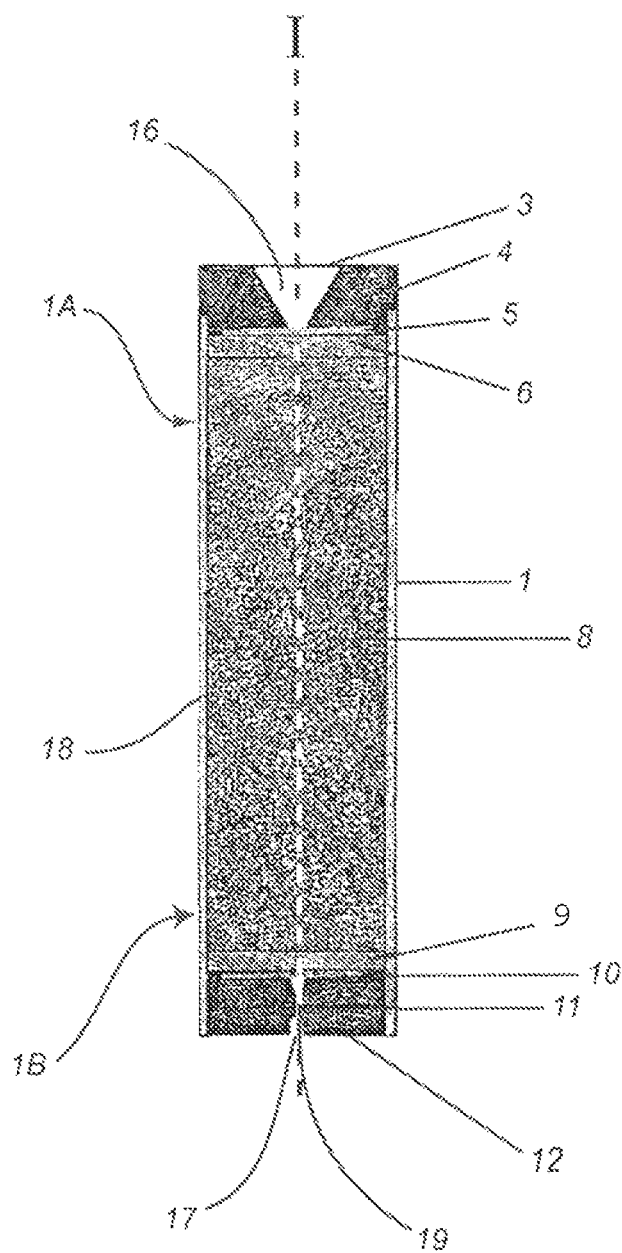


Figure 2

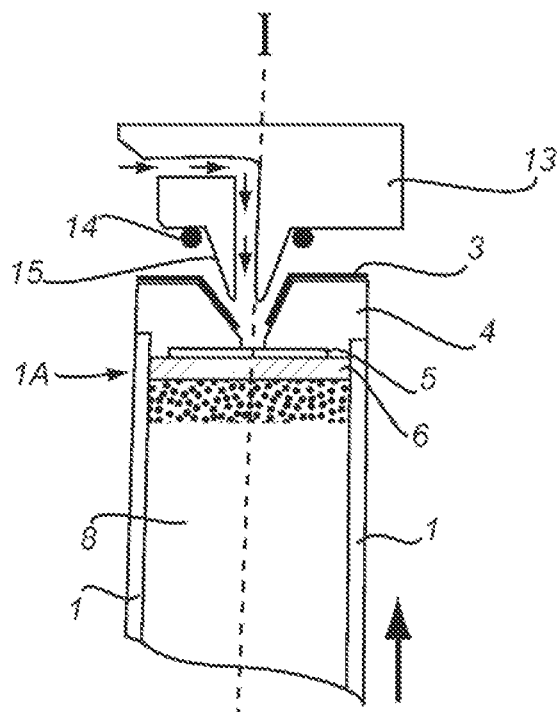


Figure 3

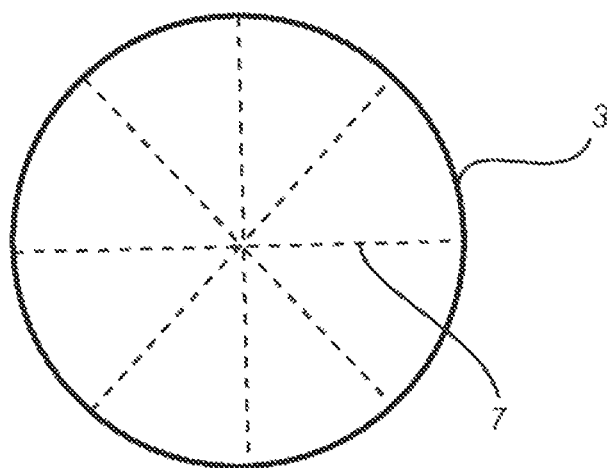
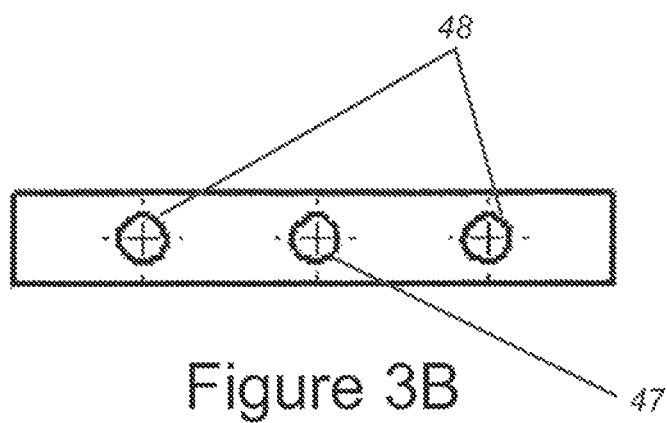
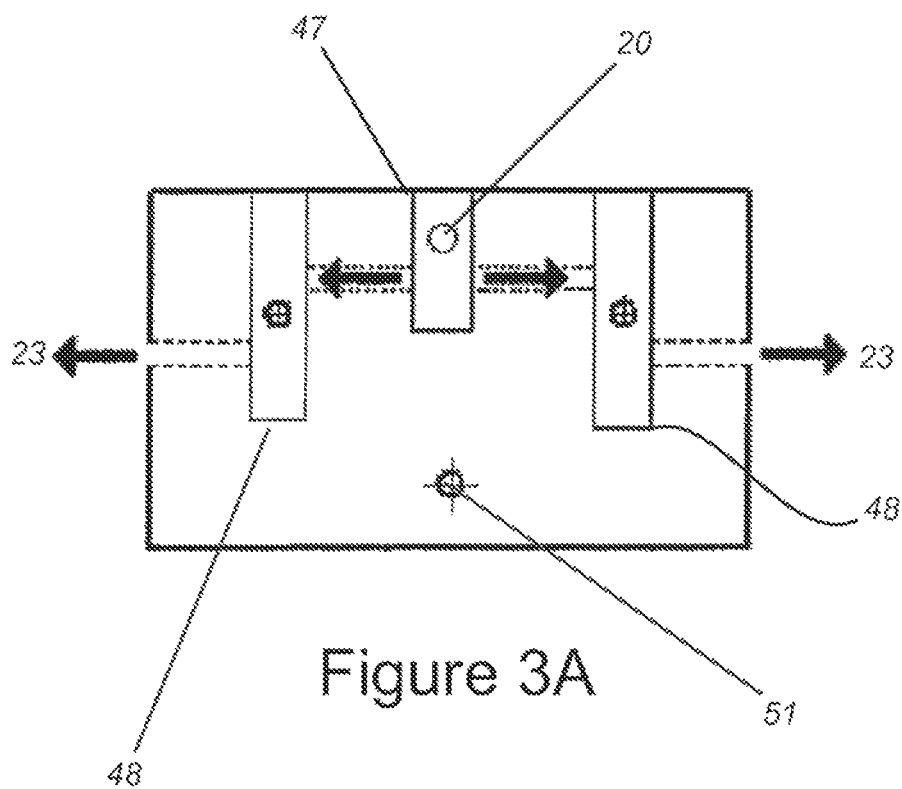


Figure 4



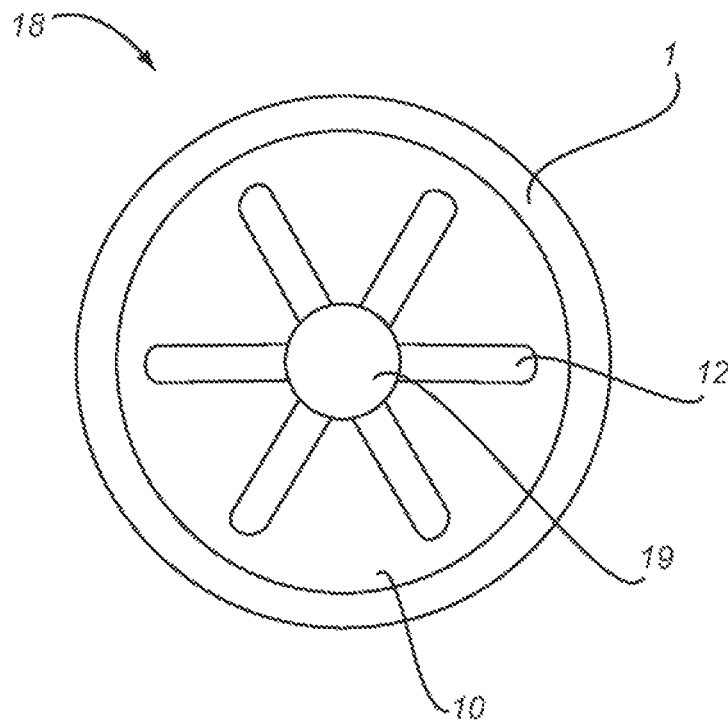


Figure 5

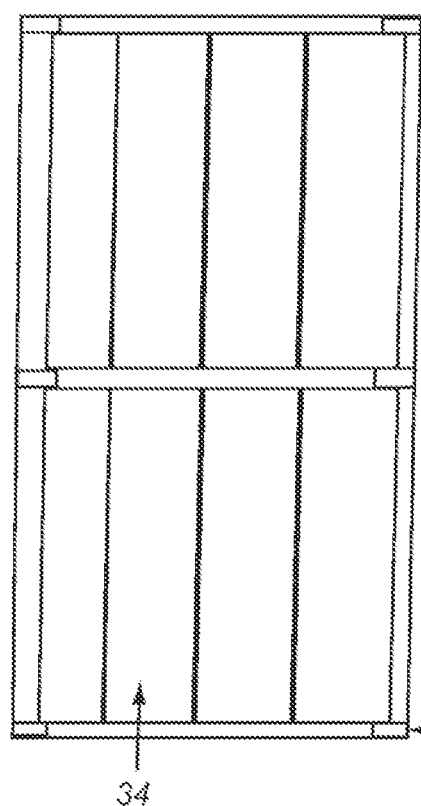


Figure 6A

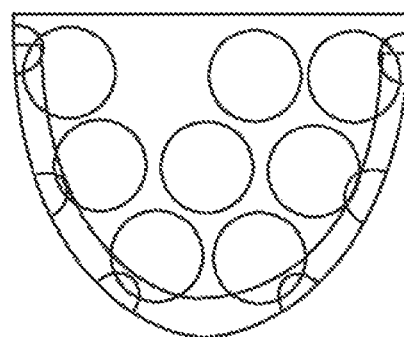


Figure 6B

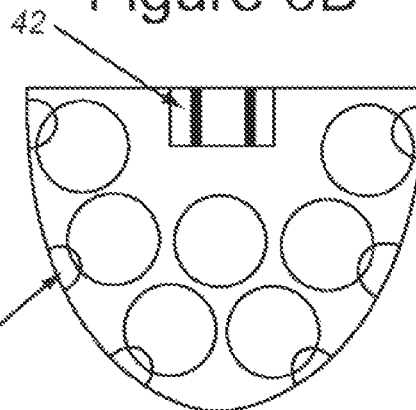


Figure 6C

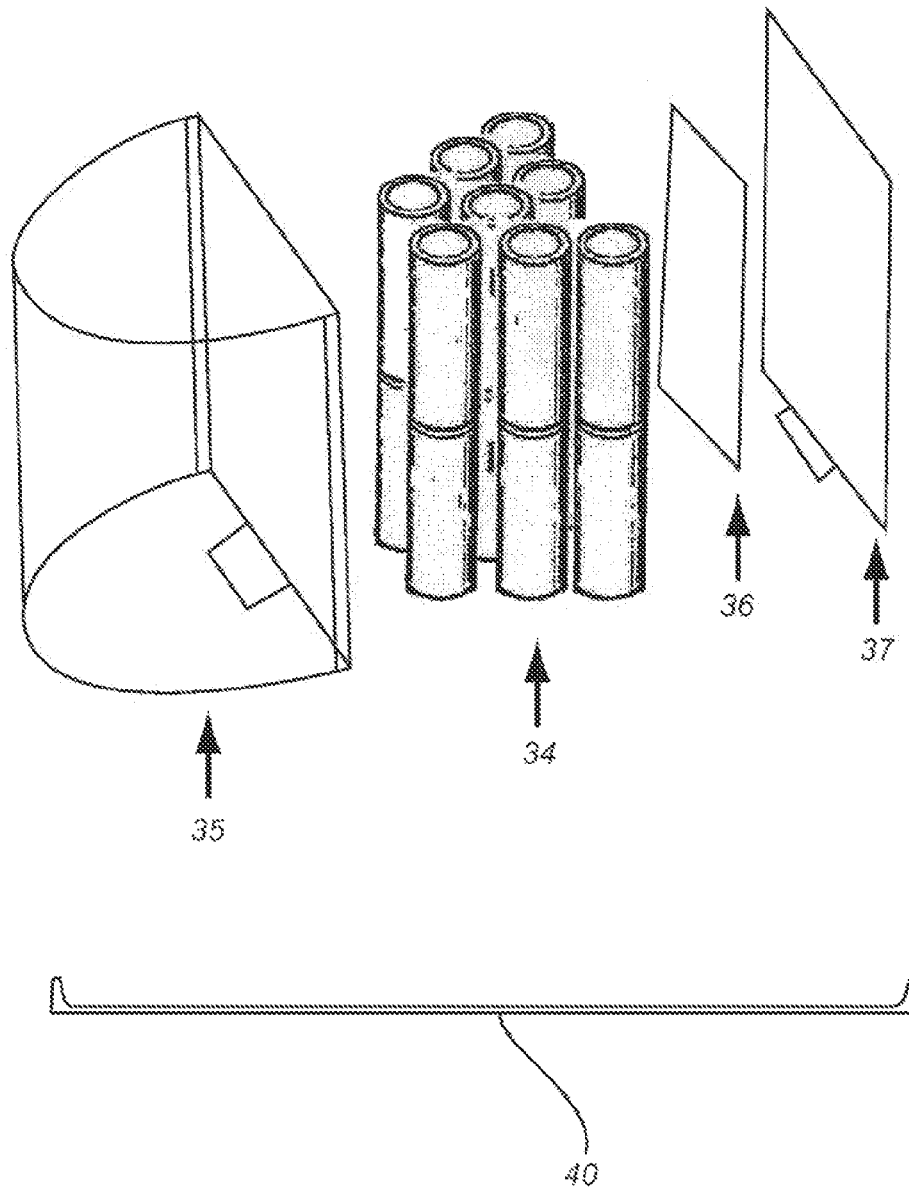


Figure 7

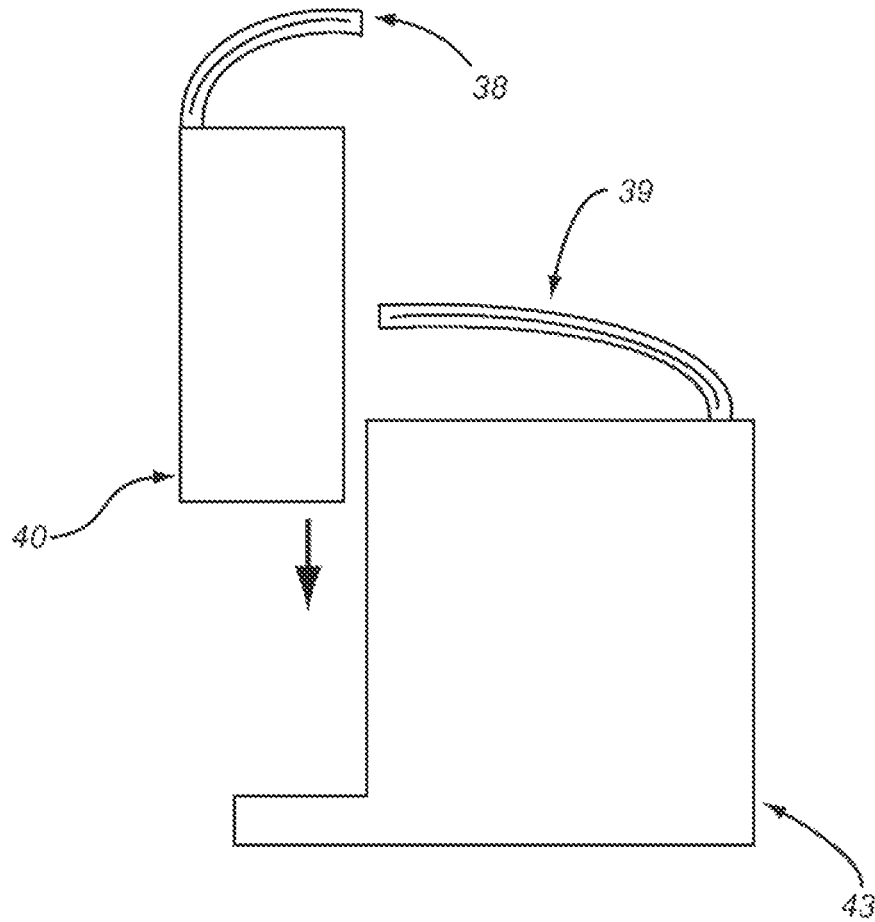


Figure 8

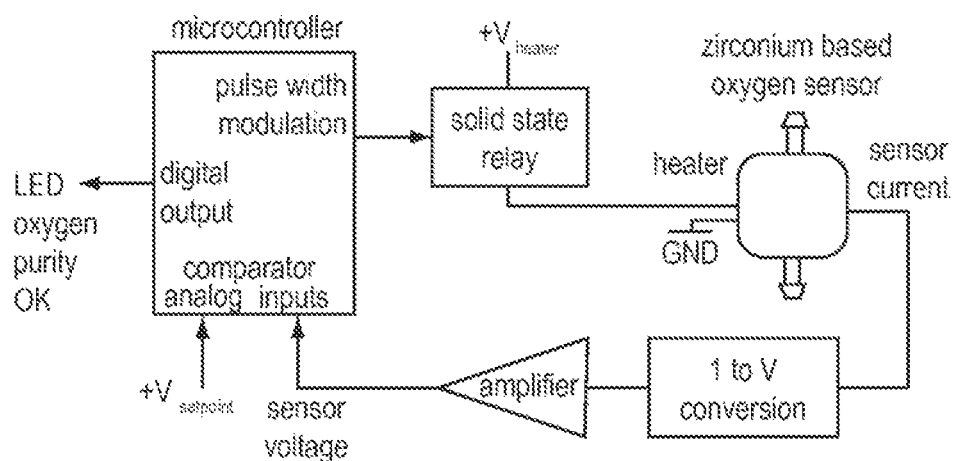


Figure 9

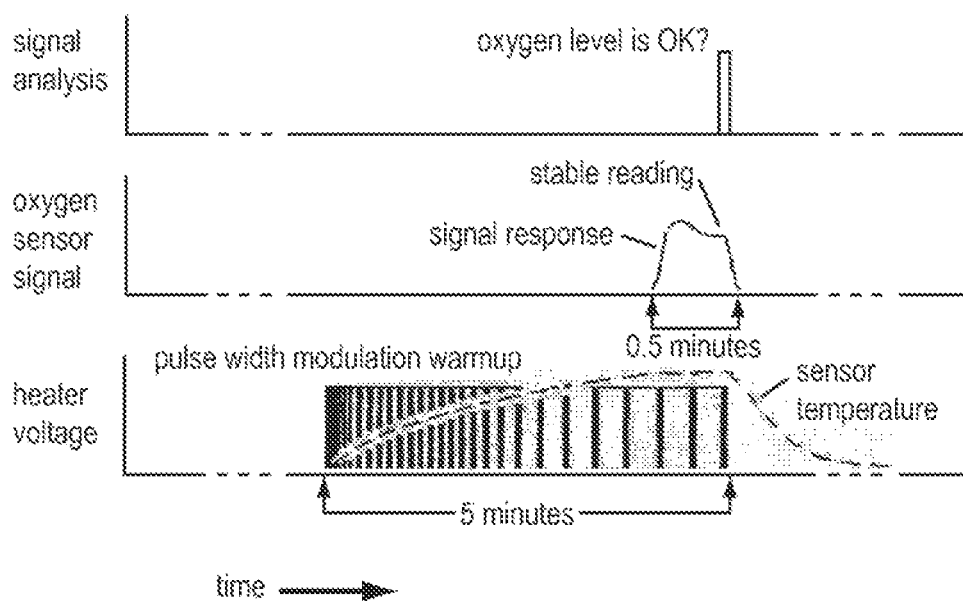


Figure 10

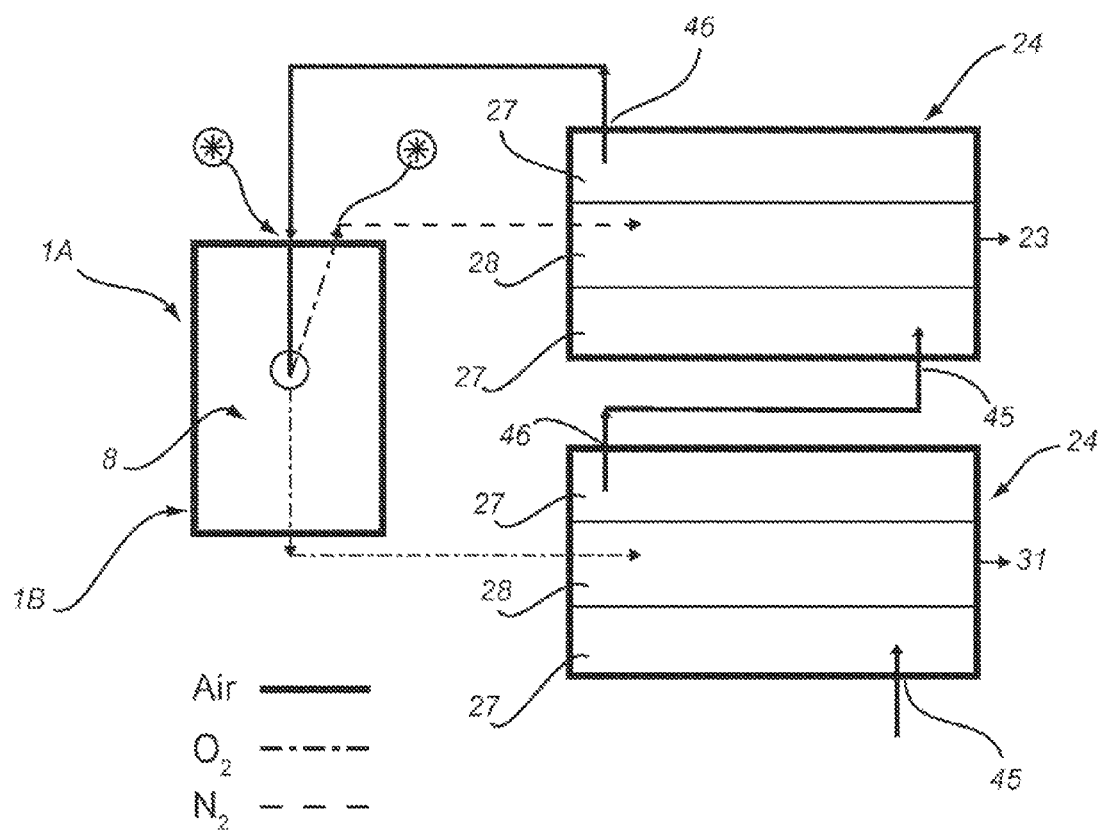


Figure 11

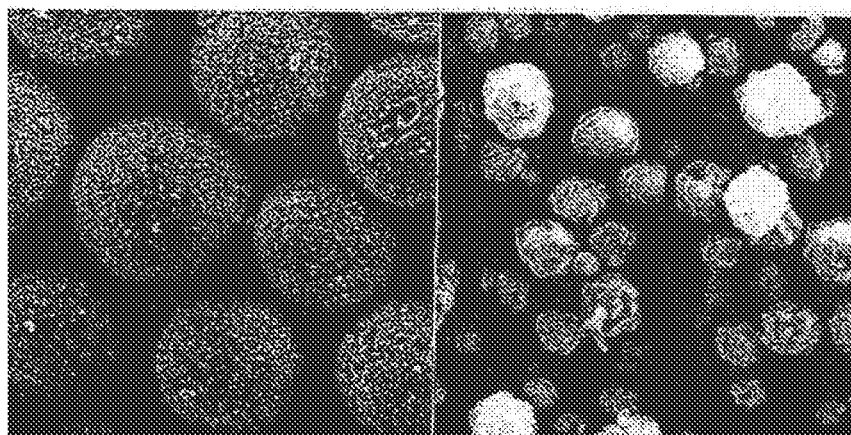


Figure 12A

Figure 12B

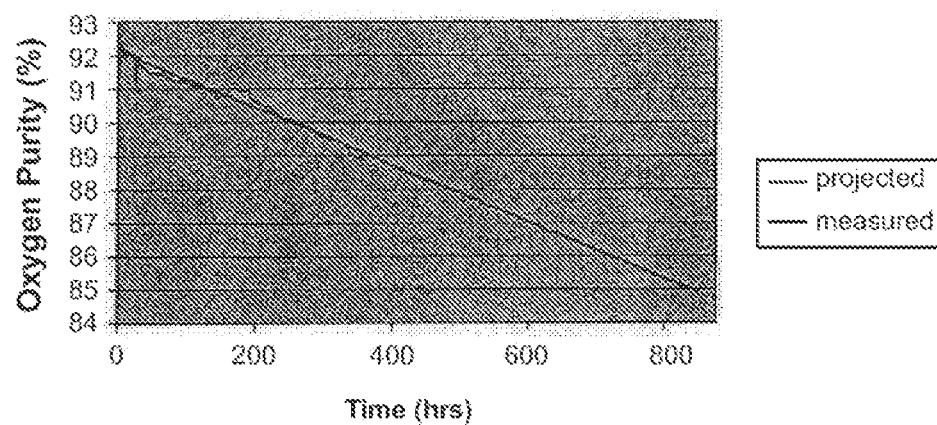


Figure 13

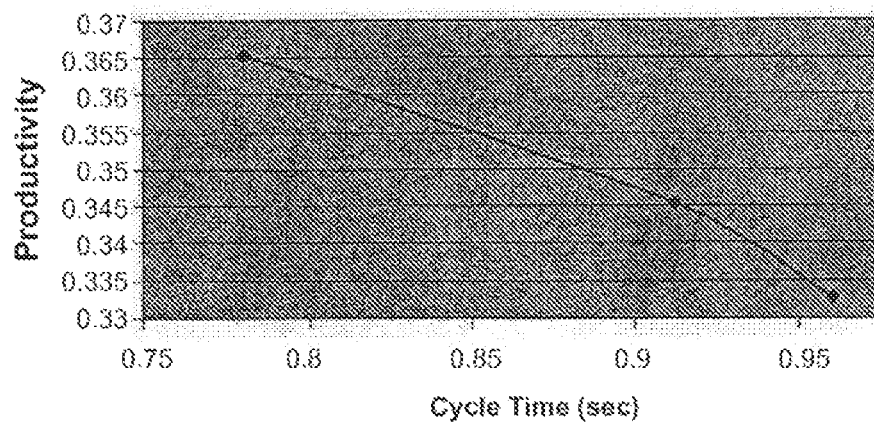


Figure 14

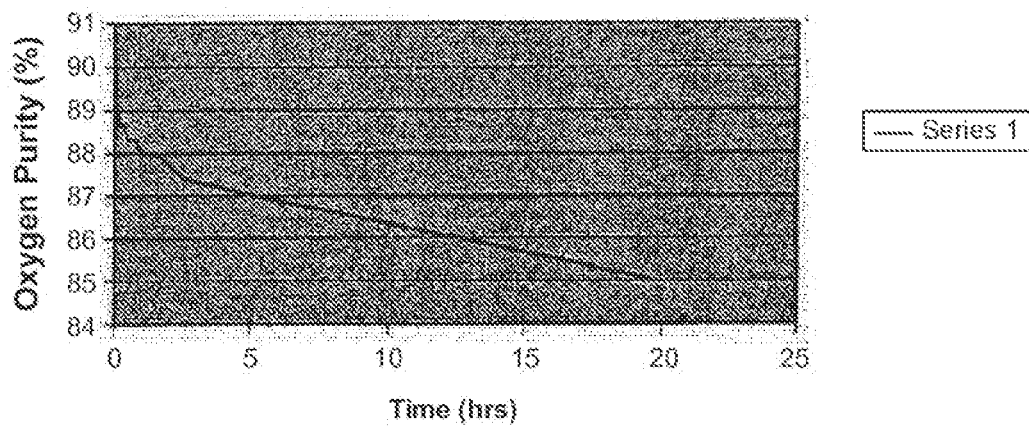


Figure 15

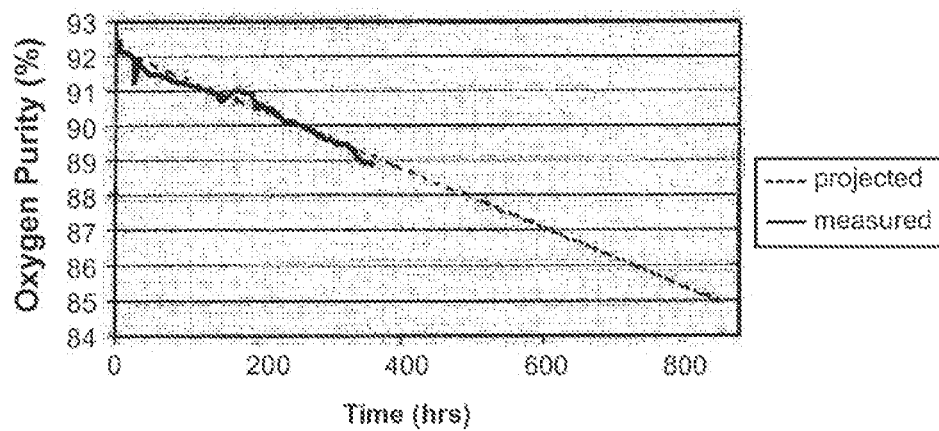


Figure 16

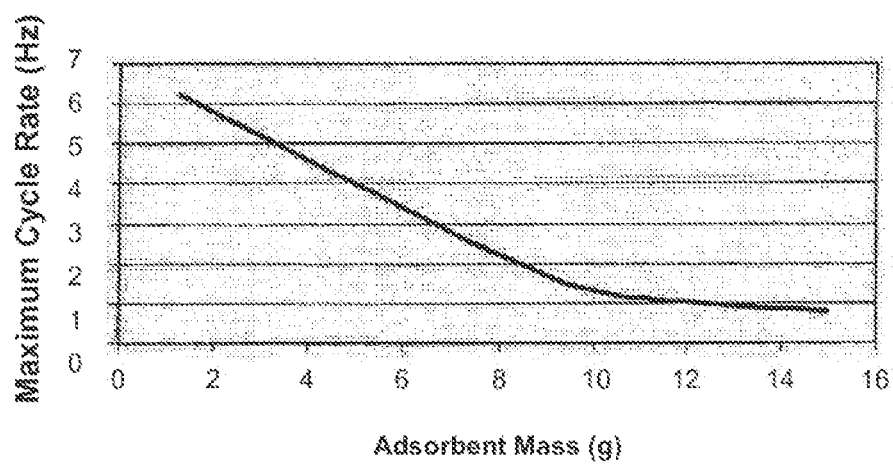


Figure 17

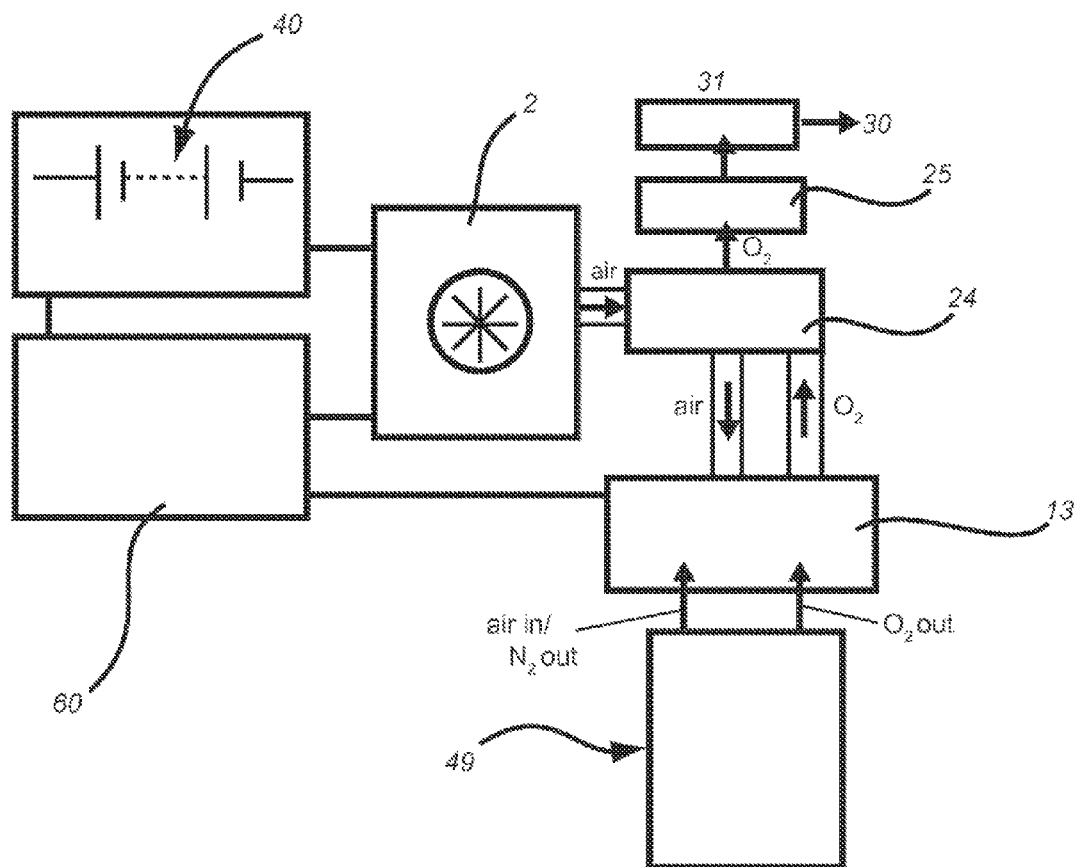


Figure 18

**ULTRA RAPID CYCLE PORTABLE OXYGEN
CONCENTRATOR****CROSS-REFERENCE TO RELATED
APPLICATIONS**

This application is a continuation of U.S. application Ser. No. 13/499,943 filed Apr. 3, 2012, now U.S. Pat. No. 8,894,751 issued Nov. 25, 2014, which is a U.S. national phase patent application under 35 U.S.C. §371 of International Patent Application No. PCT/US2010/51419 filed Oct. 5, 2010, which claims priority under PCT Article 8 to U.S. Application No. 61/264,069 filed Nov. 24, 2009 and U.S. Application No. 61/248,712 filed Oct. 5, 2009, each of which is incorporated herein by reference in its entirety.

REFERENCE TO GOVERNMENT GRANTS

Portions of the disclosure herein may have been supported in part by grants from the National Science Foundation/Small Business Innovative Research Grant No. 0419821 and the National Institutes of Health/Small Business Technology Transfer Research Grant No. 1 R41 HL080825-01. The United States Government may have certain rights in this application.

FIELD OF THE INVENTION

The invention relates generally to devices, systems, and methods for carrying out adsorption processes for separating and purifying fluid mixtures and, more particularly, to portable devices, systems, and methods for separation and purification processes employing advanced molecular sieve materials, especially for concentrating medical oxygen.

BACKGROUND OF THE INVENTION

The supply of therapeutic oxygen to patients in homes and other residential settings is an important and growing segment of the health care industry. Oxygen can be supplied to a patient by liquid or compressed oxygen with an appropriate vaporization or pressure regulation system and a gas delivery cannula. Alternatively, oxygen can be supplied by the generation of oxygen using a small onsite air separation device or medical oxygen concentrator located near the patient that delivers the generated oxygen via a cannula.

Respiratory oxygen usage rates typically range up to 3 LPM (liters per minute at 22° C. and 1 atmosphere pressure) for ambulatory patients with relatively low oxygen requirements, up to 5 LPM for patients with more serious respiratory problems and possibly limited mobility, and in certain cases up to 10 LPM for those with the most serious respiratory problems and more limited mobility. A patient initially may require a higher oxygen supply rate during an illness and later may require less oxygen as recovery is achieved. Alternatively, a patient may require increasing oxygen rates as a chronic condition worsens. A conserver may be used to provide oxygen flow only when the patient inhales, thereby reducing the amount of oxygen required by eliminating the supply of oxygen that is wasted when the patient exhales.

Portable medical oxygen concentrators often are preferred over liquid or compressed oxygen supply systems in home and residential settings, and small air separation devices for these applications are being developed by numerous vendors in the home health care field. Patients typically are encouraged to be ambulatory whenever possible to increase the effectiveness of oxygen therapy and improve their overall

health. The portability of a medical oxygen concentrator therefore is an important feature allowing the patient to move about easily and comfortably. To maximize portability and ease of use, the medical oxygen concentrator must be designed to have minimum weight and compact dimensions. Patient ambulation time can be maximized by the use of a conserver.

There is a need in the home health care field for an improved, lightweight, battery-powered portable oxygen concentrator for delivering oxygen product to ambulatory patients. These patients typically require a concentrator that can generate up to about 3 LPM of oxygen on a continuous basis and that includes a built-in conserver that maximizes ambulation time. The invention is directed to these, as well as other, important ends.

SUMMARY OF THE INVENTION

The invention provides lightweight, portable oxygen concentrators that operate using an ultra rapid, sub one second, adsorption cycle based on advanced molecular sieve materials. The amount of sieve material utilized is a fraction of that used in conventional portable devices. This dramatically reduces the volume, weight, and cost of the device. Innovations in valve configuration, moisture control, case and battery design, and replaceable sieve module are described. Patients with breathing disorders and others requiring medical oxygen are provided with a long lasting, low cost alternative to existing portable oxygen supply devices.

In one embodiment, the invention is directed to removable modules for a portable oxygen concentrator, comprising:

at least one cartridge, comprising:

a housing having a feed end and a product end;

at least one input port for incoming air flow in said feed end;

a feed end plug;

a diffusion channel in said feed end;

an optional rupture plate for said input port;

at least one adsorbent bed contained in said housing, wherein said adsorbent bed comprises at least one molecular sieve material having an average particle size of about 60 μm to 180 μm and having a substantially spherical shape;

wherein said adsorbent bed has an aspect ratio of length to diameter of less than about 6;

an optional fibrous pad positioned at either end or both ends of said adsorbent bed;

at least one output port for an oxygen-enriched product flow in said product end; and

a product end plug comprising a gas flow controls and at least one collection channel;

at least one enriched-oxygen product tube, comprising:

an input end plug;

an oxygen input port in said input end plug;

an output end plug;

an oxygen output port in said output end plug; and

an optional rupture plate for said oxygen output port; and a product end block comprising at least one passageway for transport of said oxygen-enriched product;

wherein said at least one cartridge and said at least enriched-oxygen product tube are connected to said product end block.

In another embodiment, the invention is directed to manifolds for portable oxygen concentrators, comprising:

a solid body having a passageway for transporting fluid;

a connection for fresh air from a compressor to said passageway for transporting fluid;

3

a 2-way compressor valve within said connection for fresh air;

at least one first connection from said passageway to a cartridge comprising an adsorbent bed for separating air components;

at least one second connection to said passageway from an oxygen-enriched product source;

a valve within said second connection;

two 3-way adsorbent bed valves within said passageway for transporting fluids positioned on both sides of said first connection;

at least one exhaust port;

an optional piercing mechanism attached to said solid body at said one first connection; and

an optional piercing mechanism attached to said solid body at said one second connection.

In yet other embodiments, the invention is directed to portable oxygen concentrators, comprising:

at least one removable module described herein;

a compressor;

an optional moisture control unit comprising a getter material for moisture positioned between said compressor and said inlet port of said removable module;

a manifold to control gas flow into and out of said removable module comprising:

a solid body having a passageway for transporting fluid;

a connection for fresh air from a compressor to said passageway for transporting fluid;

a 2-way compressor valve within said connection for fresh air;

at least one first connection from said passageway to a cartridge comprising an adsorbent bed for separating air components;

at least one second connection to said passageway from an oxygen-enriched product source;

a valve within said second connection;

two 3-way adsorbent bed valves within said passageway for transporting fluids positioned on both sides of said first connection;

at least one exhaust port;

an optional piercing mechanism attached to said solid body at said one first connection; and

an optional piercing mechanism attached to said solid body at said one second connection;

at least one optional moisture control unit;

an optional oxygen sensor; and

at least one battery cell.

In other embodiments, the invention is directed to systems, comprising:

a portable oxygen concentrator described herein;

a docking station; and

a battery recharger.

In another embodiment, the invention is directed to methods of producing an oxygen-enriched gas flow, comprising:

compressing an ambient air flow comprising oxygen and nitrogen to form a compressed air flow;

transporting said compressed flow through an adsorbent bed to adsorb at least a portion of said nitrogen to form an oxygen-enriched gas flow; and

removing said oxygen-enriched gas flow to form an oxygen-enriched product;

wherein the pressure drop across said adsorbent bed is less than about 50 kPa.

The method may further comprise the step of desorbing from said adsorbent bed said portion of said nitrogen. The method may further comprise the step of exhausting said portion of said nitrogen desorbed from said adsorbent bed. The method

4

may further comprise the step of collecting said oxygen-enriched product. The oxygen-enriched product is delivered to a recipient in need thereof.

In another embodiment, the invention is directed to methods of reducing the power requirement of a zirconium-based oxygen sensor, comprising:

intermittently operating said zirconium-based oxygen sensor.

In another embodiment, the invention is directed to methods of reducing the power requirement of a zirconium-based oxygen sensor comprising a heater and a heater control, said method comprising:

modulating the pulse-width of said heater control of said heater during operation of said zirconium-based oxygen sensor.

In another embodiment, the invention is directed to methods of increasing the lifetime of an electrochemical oxygen sensor in a portable oxygen concentrator, comprising:

periodically turning gas flow off to said electrochemical oxygen sensor in said portable oxygen concentrator.

In another embodiment, the invention is directed to portable oxygen concentrator systems, comprising:

a portable oxygen concentrator module having a first partial handle portion and at least one removable module having an enriched-oxygen product tube and at least one cartridge comprising adsorbent; and

a battery pack module having a second partial handle portion;

wherein said battery pack module releasably connects to said portable oxygen concentrator module;

wherein said first partial handle portion and said second partial handle portion align to form a single integrated handle; and

wherein said first partial handle portion inserts and secures said removable module in said portable oxygen concentrator system by lever action.

In another embodiment, the invention is directed to methods of reducing moisture content and increase throughput in a portable oxygen concentrator providing an enriched-oxygen product, comprising:

providing a moisture control unit comprising a getter material that scavenges moisture when said portable oxygen concentrator is not operating;

providing compressed air comprising oxygen and nitrogen to an adsorbent bed to adsorb said nitrogen and produce said enriched-oxygen product;

wherein said getter material is gas impervious to prevent contamination of said enriched-oxygen product by said nitrogen in said compressed gas.

BRIEF DESCRIPTION OF THE DRAWINGS

The accompanying drawings, which are included to provide a further understanding of the invention and are incorporated in and constitute a part of this specification, illustrate embodiments of the invention and together with the description serve to explain the principles of the invention.

FIG. 1 is a cross-sectional view of the removable module 49 and the manifold 12 portions of a portable oxygen concentrator 43.

FIG. 1A is a schematic diagram of a removable module 49 having two cartridges 18, an enriched oxygen product tube 22, and inlet particulate air filter 61.

FIG. 2 is a vertical cross-section of the removable module 18 showing a rupture plate 3 covering the feed end plug 4 to

5

seal the adsorbent bed **8** and prevent contamination, especially contamination from moisture, during storage prior to use.

FIG. **3** is a vertical cross-section of the piercing mechanism **15** and module connections to the manifold **13** with the rupture plate **3** (shown after piercing by the piercing mechanism **15**).

FIG. **3A** is a vertical cross-section of the valving in the manifold **13** of one embodiment. FIG. **3B** is a top view of the valving in the manifold **13** of one embodiment.

FIG. **4** is a plan view of the rupture plate **3** showing a pre-weakened pattern **7**, which permits easy opening with the piercing mechanism **15** (not shown).

FIG. **5** is a plan view of the removable module **18** showing product end plug **12**, center feed hole **19**, and collection channel **10**.

FIGS. **6A**, **6B**, and **6C** are back, top and bottom views, respectively, of the battery pack configured with fifteen cells (eight on top layer, seven on bottom layer).

FIG. **7** is an exploded perspective view of the fifteen cell battery pack with the battery cells, PCM unit, and back of the battery case.

FIG. **8** is a side view of a portable oxygen concentrator system having a battery pack module and portable oxygen concentrator module.

FIG. **9** is a block diagram of an oxygen sensor electronics.

FIG. **10** is an illustration of the oxygen sensor signal timing.

FIG. **11** is a schematic view of the moisture control unit of the portable oxygen concentrator.

FIGS. **12A** and **12B** are scanning electron micrographs images detailing the regular, spherical nature of the adsorbents employed in the invention. FIG. **12A** shows the individual adsorbent particle beads. FIG. **12B** shows the small zeolite crystal component parts of the individual adsorbent particle beads.

FIG. **13** is a plot of % oxygen purity as a function of time in hours to show the drop in oxygen purity (input air had a relative humidity of 75%).

FIG. **14** is a plot of productivity as a function of cycle time in seconds for a 0.7 inch ID×3 inch long adsorbent bed (concentrator).

FIG. **15** is a plot of % oxygen purity as a function of time in hours to show the drop in oxygen purity using adsorbent beds that hold about 0.95 g of adsorbent.

FIG. **16** is a plot of % oxygen purity (projected and measured) as a function of time in hours to show the drop in oxygen purity using adsorbent beds that hold about 10 g of adsorbent.

FIG. **17** is a plot showing the maximum cycle rate (in Hz) as a function of adsorbent mass (in grams) achieving at least 85% oxygen purity.

FIG. **18** is a block diagram of some of the components of an embodiment of the portable oxygen concentrator, including removable module **49**, manifold **13**, compressor **2**, moisture control unit **24**, oxygen sensor **25**, conserver **31**, cannula **30** (not shown), battery pack **40**, and electronic controls **60**.

Part Number	Description
1	Housing
1A	Feed end of housing
1B	Product end of housing
2	Compressor
3	Rupture plate
4	Feed end plug

6

-continued

Part Number	Description
5	Diffusion channel
6	Fibrous pad
7	Pre-weakened pattern
8	Adsorbent bed
9	Fibrous pad
10	Collection channel
11	Gas flow control orifice
12	Product end plug
13	Manifold
14	Scal
15	Piercing mechanism
16	Input port
17	Output port
18	Cartridge
19	Center feed hole
20	Passageway for compressed fresh air
21	Connection for an enriched oxygen product
22	Enriched oxygen product tube
23	Exhaust port
24	Moisture control unit
25	Oxygen sensor
26	Battery cell
27	Outer chamber
28	Inner chamber
29	Muffler
30	Cannula
31	Conserver
32	Docking station
33	Battery recharger
34	Battery cell
35	Battery pack case
36	Protection circuit module
37	Back plate
38	Battery pack handle
39	Portable oxygen concentrator handle
40	Battery pack module
41	Tabs
42	Recessed female connectors for positive and negative terminals
43	Portable oxygen concentrator module (without battery pack module)
44	Back pressure device
45	Entry port (FIG. 11)
46	Exit port (FIG. 11)
47	2-way compressor valve
48	3-way adsorbent bed valve
49	Removable module
50	Passageway to/from cartridge
51	Passageway from enriched-oxygen product tube 22
52	Oxygen input port in enriched oxygen product tube 22
53	Oxygen output port in enriched oxygen product tube 22
54	Manifold passageway
55	Solid body
56	Valve
57	Input end plug in enriched-oxygen product tube 22
58	Output end plug in enriched-oxygen product tube 22
59	Product end block
60	Electronic controls
61	Inlet particulate air filter

DETAILED DESCRIPTION OF THE INVENTION

The invention provides lightweight, portable oxygen concentrators that operate using an ultra rapid, sub one second, adsorption cycle based on advanced molecular sieve materials. The amount of sieve material utilized is a fraction of that used in conventional portable devices. This dramatically reduces the volume, weight, and cost of the device. Innovations in valve configuration, moisture control, case and battery design, and replaceable sieve module are described. Patients with breathing disorders and others requiring medical oxygen are provided with a long lasting, low cost alternative to existing portable oxygen supply devices.

Definitions

The following definitions are provided for the full understanding of terms used in this specification.

As used herein, the article “a” means “at least one”, unless the context in which the article is used clearly indicates otherwise.

As used herein, the terms “separation” and “separating” mean the act or process of isolating or extracting from or of becoming isolated from a mixture (a composition of two or more substances that are not chemically combined).

As used herein, the terms “purification” and “purifying” means the act or process of separating and removing from anything that which is impure or noxious, or heterogeneous or foreign to it.

As used herein, the term “fluid” refers to a continuous amorphous substance that tends to flow and to conform to the outline of its container, including a liquid or a gas, and specifically includes solutions (where solids dissolved in the liquid or gas) and suspensions (where solids are suspended in liquid or gas).

As used herein, the term “portable” refers to a device that may be capable of being carried or moved. Preferably, the term refers to a device that may be carried by an adult or child with little or no effort. However, the term also refers to a device that is not permanently affixed to a permanent structure and is of sufficiently low mass and bulk that it may be easily transported as part of a vehicle or transportation device. Preferably, the portable oxygen concentrators of the invention weigh less than about 5 kg.

As used herein, the term “chamber” refers to a three-dimensional volume having an generally solid outer surface that is generally elliptical or circular in cross-sectional shape.

The term “adsorbent” or “adsorbent contactor” refers to an adsorbent or a membrane containing an adsorbent.

Reference will now be made in detail to the preferred embodiments of the invention, examples of which are illustrated in the drawings and the examples. This invention may, however, be embodied in many different forms and should not be construed as limited to the embodiments set forth herein. In addition and as will be appreciated by one of skill in the art, the invention may be embodied as a product, method, system or process.

In one embodiment, the invention is directed to removable modules for a portable oxygen concentrator, comprising:

- at least one cartridge, comprising:
- a housing having a feed end and a product end;
- at least one input port for incoming air flow in said feed end;
- a feed end plug;
- a diffusion channel in said feed end;
- an optional rupture plate for said input port;
- at least one adsorbent bed contained in said housing, wherein said adsorbent bed comprises at least one molecular sieve material having an average particle size of about 60 μm to 180 μm and having a substantially spherical shape;
- wherein said adsorbent bed has an aspect ratio of length to diameter of less than about 6;
- an optional fibrous pad positioned at either end or both ends of said adsorbent bed;
- at least one output port for an oxygen-enriched product flow in said product end; and
- a product end plug comprising a gas flow controls and at least one collection channel;
- at least one enriched-oxygen product tube, comprising:
- an input end plug;
- an oxygen input port in said input end plug;

an output end plug;

an oxygen output port in said output end plug; and
an optional rupture plate for said oxygen output port; and
a product end block comprising at least one passageway for transport of said oxygen-enriched product;
wherein said at least one cartridge and said at least enriched-oxygen product tube are connected to said product end block.

In another embodiment, the invention is directed to manifolds for a portable oxygen concentrator, comprising:

a solid body having a passageway for transporting fluid;
a connection for fresh air from a compressor to said passageway for transporting fluid;
a 2-way compressor valve within said connection for fresh air;

at least one first connection from said passageway to a cartridge comprising an adsorbent bed for separating air components;

at least one second connection to said passageway from an oxygen-enriched product source;

a valve within said second connection;
two 3-way adsorbent bed valves within said passageway for transporting fluids positioned on both sides of said first connection;

at least one exhaust port;
an optional piercing mechanism attached to said solid body at said one first connection; and
an optional piercing mechanism attached to said solid body at said one second connection.

In another embodiment, the invention is directed to portable oxygen concentrators, comprising:

at least one removable module of claim 1;

a compressor;

an optional moisture control unit comprising a getter material for moisture positioned between said compressor and said inlet port of said removable module;

a manifold to control gas flow into and out of said removable module comprising:

a solid body having a passageway for transporting fluid;
a connection for fresh air from a compressor to said passageway for transporting fluid;
a 2-way compressor valve within said connection for fresh air;

at least one first connection from said passageway to a cartridge comprising an adsorbent bed for separating air components;

at least one second connection to said passageway from an oxygen-enriched product source;

a valve within said second connection;

two 3-way adsorbent bed valves within said passageway for transporting fluids positioned on both sides of said first connection;

at least one exhaust port;
an optional piercing mechanism attached to said solid body at said one first connection; and

an optional piercing mechanism attached to said solid body at said one second connection;

at least one optional moisture control unit;

an optional oxygen sensor; and

at least one battery cell.

To more fully understand the invention, the various embodiments will be described with respect to the figures.

FIG. 18 is a block diagram of some of the components of an embodiment of the portable oxygen concentrator, including the removable module 49, manifold 13, compressor 2, moisture control unit 24, oxygen sensor 25, conserver 31, cannula 30 (not shown), battery pack 40, and electronic controls 60.

FIG. 1 is a cross-sectional view of the removable module 49 and the manifold 12 portions of a portable oxygen concentrator 43 showing compressed air flow from a compressor 20 (not shown).

The removable module 49 in the embodiment of FIG. 1 has two cartridges 18. The cartridge 18 has a housing 1 having a feed end 1A and a product end 1B; at least one input port 16 for incoming air flow in said feed end 1A; a feed end plug 4; a diffusion channel 5 in said feed end 1A; an optional rupture plate 3 for said input port 16; and at least one adsorbent bed 8 contained in said housing 1, at least one output port 17 for an oxygen-enriched product flow in said product end 1B; and a product end plug 12 comprising a gas flow controls 11 and at least one collection channel 10. The adsorbent bed comprises at least one molecular sieve material having an average particle size of about 60 μm to 180 μm and having a substantially spherical shape. The adsorbent bed has an aspect ratio of length to diameter of less than about 6. Optional the cartridge has fibrous pad 6, 9 positioned at either end or both ends of said adsorbent bed.

The removable module 49 in the embodiment of FIG. 1 has at least one enriched-oxygen product tube 22, which has an input end plug 57; an oxygen input port 52 in said input end plug 57; an output end plug 58; an oxygen output port 53 in the output end plug 58; and an optional rupture plate 3 for the oxygen output port.

The removable module 49 in the embodiment of FIG. 1 has a product end block 59 has passageway 19 for transport of said oxygen-enriched product. Each cartridge 18 and the enriched-oxygen product tube 22 are connected to said product end block 59.

The portable oxygen concentrator in the embodiment of FIG. 1 also has a manifold 13 to control gas flow into and out of the removable module 18. The manifold has a solid body 55 having a passageway for transporting fluid 54. Within the solid body, there is also a connection for fresh air 20 from a compressor 2 to the passageway for transporting fluid 54 with a 2-way compressor valve 47 within the connection for fresh air 20, a first connection 50 from the passageway to a cartridge, a second connection 51 to the passageway from an oxygen-enriched product source. Also, there is a valve 56 within the second connection 51. Two 3-way adsorbent bed valves 48 are found within the passageway for transporting fluids and are positioned on both sides of said first connection 50. The passageway leads to an exhaust port 23. The manifold optionally has a piercing mechanism 15 attached to the solid body at the first connection and an optional piercing mechanism 15 attached to the solid body at the second connection.

FIG. 1A is a schematic diagram of a removable module 49 having two cartridges 18, an enriched oxygen product tube 22, and inlet particulate air filter 61.

FIG. 2 is a vertical cross-section of the cartridge 18 of the removable module 49 of one embodiment of the invention showing a rupture plate 3 covering the feed end plug 4 to seal the adsorbent bed 8 and prevent contamination, especially contamination from moisture, during storage prior to use. Housing 1 has a feed end 1A (which is also the exhaust end with respect to the nitrogen exhausted from the device) and a product end 1B (with respect to the oxygen-enriched product gas). In the feed end (i.e., where the compressed fresh air is received into removable module), there is at least one input port 16 for incoming air flow in said feed end, a feed end plug 4 (which can be made from such materials as polymers or lightweight metals), a diffusion channel 5, and an optional rupture plate 3 for said input port. In the product end (i.e., where one of the fluid flows in enriched in oxygen after passing through the adsorbent beds described herein), there is

a product end plug 12 comprising a gas flow control orifice 11, at least one collection channel 10, and at least one passageway (center feed hole 19) for transport of said fluid product, and an optional rupture plate 3 for said output port 17. Housed within the removable module is at least one adsorbent bed 8 contained in said housing 1, wherein said adsorbent bed comprises at least one molecular sieve material having an average particle size of about 60 μm to 180 μm and having a substantially spherical shape. The adsorbent bed has an aspect ratio of length to diameter of less than about 6. Optionally, a fibrous pad 6, 9 may be positioned at either end of said adsorbent bed.

FIG. 3 is a vertical cross-section of the piercing mechanism 15 and module connections to the manifold 13 with the rupture plate 3 (shown after piercing by the piercing mechanism 15). As the removable module 18 is moved toward the piercing mechanism on the manifold 13, the rupture plate 3 is pierced thereby permitted compressed fresh air from the compressor 2 (not shown) to enter the feed end 1A of the removable module 18 through the feed end plug 4 into the diffusion channel 5 through the fibrous pad 6 and finally into the adsorbent bed 8. A seal 14, such as an O-ring or gasket, seals the connection.

FIG. 3A is a vertical cross-section of the valving in the manifold 13 in an embodiment having two cartridges 18 and a single enriched oxygen product tube 22. FIG. 3B is a top view of the valving in the manifold 13. In this embodiment, there are two 3-way valves 48 to control gas flow into and out of the adsorbent beds and single 2-way valve 47 to control the flow of compressed air from the compressor 2 (not shown) through the connection 20. In certain embodiments, the working components of the valves are integrated into the solid body 55 of the manifold 13 rather than mounted to it. The working components of the valves (i.e., the poppets, spools, or piezoelectric elements) are integrated into the solid body 55 to make it a more compact, lighter unit and the gas flow pathways 50, 51, and 54 are also contained within the manifold as in other arrangements where the valves are mounted onto the manifold. In certain embodiments, solenoids (not shown) actuate the valves and may either be contained within solid body 55 or may be mounted to it.

FIG. 4 is a plan view of the rupture plate 3 showing a pre-weakened pattern 7, which permits easy opening with the piercing mechanism 15 (not shown).

FIG. 5 is a plan view of the removable module 18 showing product end plug 12, center feed hole 19, and collection channel 10.

The portable oxygen concentrators (POC) of the various embodiments are designed to operate using ultra rapid cycle pressure swing adsorption where the cycles are less than one second in duration. Traditional POCs operate using cycles that are several seconds long. Pressure swing adsorption systems typically use adsorbent beds filled with spherical particles of the molecular sieve materials, especially zeolites, which preferentially adsorb nitrogen when they are filled with pressurized air, thus producing an oxygen-enriched product. When the beds are depressurized, the nitrogen is desorbed. Since the adsorption capacity for nitrogen of the beds is limited, shortening the cycle is advantageous in that it allows more output to be produced from a smaller quantity of adsorbent. Typical POCs use adsorbent beds that contain approximately 0.5 kilograms of adsorbent. The ultra rapid cycle operation of the devices of the various embodiments allows the use of adsorbent beds that contain less than about 50 grams of adsorbent. This drastic reduction in the amount of adsorbent material required allows for a significant savings in mass and volume of the portable oxygen concentrator.

To operate using cycles of less than one second duration, advanced molecular sieve materials are required. Smaller particles are utilized to allow for more rapid diffusion of gas through the porous structure of the particle. The molecular sieve particles used in the invention range in diameter from about 60 μm to about 180 μm , and the preferred diameter range is between about 80 μm and about 120 μm . Conventional technology uses particles that range in size from about 0.4 mm to about 0.8 mm. The smaller size of the adsorbents employed in the various embodiments allows gases to diffuse in and out of the beads very rapidly so cycle times of 0.15 seconds are possible. This is at least ten (10) times faster than any cycle time used in any commercial separations device. Fast cycle times equate to smaller amounts of adsorbent being required to process the same amount of gas.

The relationship between cycle rate and adsorbent quantity required is roughly an inverse relationship, i.e., doubling cycle rate from 1 cycle per second to 2 cycles per second means that the typical separations system would go from using 0.5 kg of adsorbent to using 0.25 kg adsorbent. Conventional portable oxygen concentrators typically use about 300 grams to about 450 grams of adsorbent in a system that produces about 750 ml to about 1000 ml per minute of oxygen. The portable oxygen concentrator of the invention can use as little as about 5 grams to about 30 grams to produce the same amount of oxygen per minute. The considerable weight and volume reduction may be used to decrease the device size and weight, or to increase the size and volume of the battery, thereby providing longer operating time.

The particles must also be highly spherical, because any irregularity in their shape greatly increases the pressure drop through the adsorbent bed. FIGS. 12A and 12B are scanning electron micrographs images detailing the regular, spherical nature of the adsorbents employed in the invention. FIG. 12A shows the individual adsorbent particle beads. FIG. 12B shows the small zeolite crystal component parts of the individual adsorbent particle beads.

Most currently available molecular sieve materials for air separation have a lower limit diameter of about 560 micrometers. This diameter limits how fast gases can diffuse into and out of the adsorbent bead. This is why the fastest cycle time for commercially available oxygen concentrators is about 4 seconds. Most researchers believed that making the beads smaller would increase tortuosity to the point that an energy wasting pressure drop would be introduced. The present research showed that this was the case with irregular shaped adsorbents, but highly spherical beads, as small as 100 micrometers in diameter did not introduce too large a pressure drop as long as a certain sieve bed length to cycle rate ratio was maintained. This ratio is about 10 cm bed length to one second of cycle time. For example, a 0.5 second cycle time would require a 5 cm bed length. If for a given cycle rate, a larger throughput is required, the sieve beds may be paralleled. For example, a pressure swing adsorption system having two beds that operate in alternating fashion, having dimensions of 7 cm long by 2 cm in diameter, can produce about 750 ml per minute of 94% purity oxygen at a cycle time of 0.7 seconds. If a production rate of 1500 ml per minute is required, the same cycle rate may be used by paralleling with two additional sieve beds having parallel inlet and outlet ports. Thus an oxygen concentrator having any desired output can be manufactured.

For practical reasons, there may be a minimum bed size and maximum cycle rate for a given application. Having more sieve material equates to less frequent sieve bed exchanges. It has been discovered that two 7 cm long by 2 cm diameter

adsorbent beds strike the best balance between device size reduction and frequency of sieve bed replacement.

The molecular sieve material used in the module and portable oxygen concentrator of the invention imposes limitations upon the dimensions of the adsorbent bed. Beds longer than about 12 centimeters in length and about 2.5 centimeters in diameter are impractical due to excessive pressure drop through the bed. The preferred bed size is about 1.7 to about 2 cm in diameter, and about 7 cm to about 8 cm in length. The preferred ratio of the bed length to bed diameter is about 4.3:1. Each adsorbent bed is capable of producing a maximum of between 350 and 500 milliliters per minute of oxygen-enriched product of at least 85% purity. The beds are preferably used in pairs, and if more output is desired, multiple beds or sets of beds may be used.

Molecular sieve materials, such as zeolites, which are useful as adsorbents, are highly susceptible to contamination by water, and because of this and other factors such as particle attrition, the performance of oxygen concentrators degrades over time. Once a concentrator's performance has dropped to the extent that it is no longer able to provide adequate oxygen output (typically at least the equivalent of 2 liters per minute of 85% oxygen), the concentrator is generally replaced or the adsorbent is replaced by the manufacturer or a reseller. The life of the adsorbent is often the limiting factor in the life of the device. It is therefore advantageous to have an adsorbent that is replaceable by the user. The invention features a removable and replaceable adsorbent module that is designed to be patient friendly and require very little physical strength or dexterity to install. In certain embodiments, the module features two or more adsorbent beds, inlet ports for air that lead to each of the beds, an outlet port for the oxygen enriched product, and a product-end block that contains gas flow controls and passageways.

In a pressure swing adsorption system, the majority of the product gas is allowed to exit the system as output, and some of it is allowed to flow into the product end of the bed that is in its desorption stage in order to drive the desorbed nitrogen out of the bed and flood it with oxygen-enriched gas. Conventional oxygen concentrators achieve this by using a check valve to control the flow out of the bed, and an orifice to allow purge flow back into the bed. The invention simplifies this arrangement by using only an orifice whose diameter is selected to create sufficient pressure in the beds, control the output flow, and allow adequate purge flow. It is possible that this orifice preferentially allows free flow in one direction, while restricting it to a certain degree in the other direction. The orifices may be contained in the product-end block 59 of the module, as may passages to allow air to flow between the adsorbent beds and to the oxygen output port 17.

The module must be sealed to prevent moisture and other contaminants from entering the adsorbent during storage and installation. The ports are covered with rupture plates that are constructed of a material that is easily pierced, such as a plastic film or an aluminum foil. In preferred embodiments, the rupture plates are adhered to the top of the molecular sieve bed. The rupture plates are preferable pre-weakened (by die-stamping, laser ablation, or some other suitable method) to ensure that they rupture in a predictable pattern.

When the module is installed into the oxygen concentrator, it connects to a manifold that controls the flow of gas in and out of the module. In certain embodiments, the manifold has a piercing mechanism that punctures the rupture plates as the module is installed. The piercing mechanism includes projections that are designed to pierce the rupture plates and push the rupture plate material aside so that it does not obstruct flow in/out of the module. In preferred embodiments, the

module has sockets into which the piercing mechanism fits that are designed to minimize head space (dead volume). In certain embodiments, the interface between the module and the manifold is sealed with a flexible seal such as an o-ring or rubber gasket. After the module is in place, installation is completed by closing a mechanism that applies pressure to the module and holds it tight against the seal to ensure an airtight fit. In certain embodiments, the mechanism has a hinged "door" that closes against the module and a latch to hold the "door" closed. This door may also comprise the handle of the device, as shown in FIG. 8.

The gas flow manifold of the oxygen concentrator includes a connection for fresh air from the compressor, a connection for the oxygen tube which leads to the oxygen reservoir, and exhaust ports, which are connected to an optional muffler. In certain embodiments, a 3-way solenoid valve is mounted in or on the manifold to control the flow into and out of each of the adsorbent beds in the module. In certain embodiments, a 2-way valve is used to control the flow of pressure air from the compressor.

In certain embodiments having two cartridges with adsorbent beds, the operating cycle of the valves is as follows:

- (1) The compressor valve opens, as does the 3-way valve connected to the first adsorbent bed, and the bed is pressurized.
- (2) The compressor valve closes, and the 3-way valve connected to the second adsorbent bed opens while the first adsorbent bed valve remains open. This step allows pressurized, oxygen-enriched gas from the first bed to partially pressurize the second bed. This step is preferred because it decreases the amount of compressed air needed, thereby increasing the energy efficiency of the device.
- (3) The 3-way valve connected to the first bed closes, and the first bed enters its exhaust/desorption phase. The compressor valve opens, and the second bed is fully pressurized.
- (4) Pressure from the second bed is used to partially pressurize the first bed (this step is the reverse of step 2).

The cycle then repeats.

The adsorbent/filter module includes a novel design that eliminates the springs commonly used to keep the bed packed tightly. With reference to FIG. 1, a housing 1, preferably in the form of a round tube constructed of aluminum, plastic, or other lightweight material, contains the bed of adsorbent material. A compliant, fibrous pad 6, 9 is placed at either end of the bed. The pad serves at least three purposes:

- (1) to act as a filter and prevent microscopic dust particles created by attrition of the adsorbent material from escaping the bed;
- (2) to act as a cushion to protect the adsorbent particles; and
- (3) to restrain the bed.

The pads 6, 9 are held in place by plugs 4, 12 that are an interference fit with the housing. The feed end plug 4 contains the socket into which the piercing mechanism 15 fits (as shown in FIG. 3), and the product end plug 12 contains the air outlet and in one possible embodiment the flow control orifice 11. The surfaces of the plugs that contact the pads may have passageways cut in them to promote diffusion of gas across the surface of the bed, or alternatively, a diffusion plate may be inserted between the plugs and the pads. The assembly is pressed together using a mechanical press to ensure that the plugs are seated firmly against the pads and the adsorbent beds, effectively locking the adsorbent particles in place. Eliminating any movement of the adsorbent particles in this fashion greatly reduces attrition.

Absorbent Beds

The adsorbent beds comprise at least one molecular sieve material having an average particle size of about 60 μm to 180 μm and having a substantially spherical shape. Preferred molecular sieve materials are aluminophosphate and silicoaluminophosphate (zeolite) types, and metal substituted aluminophosphate and silicoaluminophosphate (zeolite) molecular sieves (including, but not limited to, Li^+ , Na^+ , K^+ , Ca^{2+} , Ag^{1+} and/or Mg^{2+} -substituted aluminophosphate and silicoaluminophosphate molecule sieves), especially as part of a polymer matrix. Such zeolite adsorbents are available from Arkema Inc., Philadelphia, Pa., USA.

The sorbent structure may further comprise at least one support. In certain embodiments, at least a portion of the sorbent is adhered to or embedded in the support. Preferably, the support is a series of micro-channels, laminar, a porous electrode; a series of concentric layers, or a combination thereof.

Suitable supports for use in the methods, devices, and systems of the invention include, but are not limited to, natural clay, calcined clay, modified clay, chemically treated clay, chemically modified clay, smectite clay, kaolin clay, sub-bentonite clay, kaolin-halloysite clay, kaolin-kaolinite clay, kaolin-nacrite clay, kaolin-anauxite clay, binary matrix material, tertiary matrix material, silica-thoria, silica-alumina, silica-alumina-thoria, silica-alumina-zirconia, fibrous material, colloidal silica material, colloidal alumina material, colloidal zirconia material, colloidal mixture, surface modified amorphous silicon dioxide nanoparticles, hydrated magnesium aluminum silicate, thermoplastic polymer, thermosetting polymer, ferrous support, non-ferrous support, electrically-conductive support, dielectric support, electromagnetic receptor, or a combination thereof. The support may be applied by sintering, pyrolysis, slurring, vapor deposition, casting, electro-spraying, electrophoretic deposition, extrusion, laser deposition, electron beam deposition, silk screening, photo-lithography deposition, electrostatic self-assembly, high aspect ratio micromachining, LIGA-formation, atomic layer deposition, casting, stamping, or a combination thereof.

In certain preferred embodiments, each unit comprising sorbent structure may utilize different sorbents, wherein each of the sorbents is selective for a different component of the same or different mixture.

In certain embodiments, a combination of different molecular sieve material may be employed.

Moisture Management

The use of very small amounts of adsorbent has weight advantages but also creates challenges. All nitrogen selective adsorbents can be rendered non-functional if contaminated with moisture. Larger systems have sufficient quantities of adsorbent that moisture contamination is not a problem over the 3-year average device lifetime. Smaller devices may require periodic replacement of the adsorbent material. Because such a small quantity of adsorbent is used in the embodiments of the portable oxygen concentrator, moisture management becomes a significant issue. Two approaches may be employed to mitigate these problems in the various embodiments.

One approach is the use, for example, of an alumina or other adsorbent barrier between the compressed inlet air and the ultra-dry oxygen enriched gas (product). Moisture diffuses toward the oxygen side because of pressure differentials and H_2O partial pressure differentials (equilibrium driven). Also, a second barrier between the compressed inlet gas (air) and the nitrogen enriched waste gas may be used. The mois-

15

ture is driven toward the nitrogen waste gas side via a pressure differential mechanism. The barrier material (unlike a membrane) is not gas permeable.

In one embodiment, co-axial containers **24** are configured with the outer chamber **27** made of a lightweight metal, such as aluminum (**27** in FIG. **11**), and the inner chamber (**28** in FIG. **11**) comprising a water permeable material, described below.

In operation, feed air (directly from the compressor outlet) enters the outer chamber **27** on container **24**, labeled A, and exits to a second container **24** of similar design, labeled B. Dry product oxygen from the adsorbent bed(s) **8** is directed into the inner chamber of A **28** and exits to the conserver **31** and/or a backpressure device **44**. Waste nitrogen from the adsorbent bed **8** is directed through the inner chamber **28** of B and exits to an exhaust outlet **23** (not shown). Throughout operation of the device, a pressure differential exists across the water permeable material as well as a difference in relative humidity between the two gas streams. These differentials drive moisture from the more humid, higher pressure cylinder through the water permeable material and into the dry, lower pressure, inner chamber. This behavior is highly ideal. Moisture that inhibits oxygen separation capacity of the adsorbent is effectively removed prior to entering the sieve bed, thereby maximizing lifetime of the adsorbents. Furthermore, re-hydration of the dry oxygen is necessary before output to the patient thereby preventing patient discomfort due to ultra dry oxygen.

The prior art devices employ a variety of techniques to achieve moisture removal. These techniques include desiccant dryers, membrane filters, centrifugal devices, and the like. The moisture management system described herein is superior to the prior art techniques. The device of the invention is lightweight, low cost, and self-sustaining (i.e., does not need to be replaced during the lifetime of the concentrator). Furthermore, unlike membrane filters, the water-permeable material is impervious to nitrogen and oxygen, thus no undesirable nitrogen may enter the product stream. The water-permeable barrier comprises a material that shows high selectivity for moisture yet is not permeable to gases. This material may contain a hygroscopic adsorbent material, such as aluminum oxide, silica gel, and the like and combinations thereof, and may or may not include a binder. The material may be an extrudate, a casting, a sintered material, or an otherwise formed structure. Furthermore, the material may be incorporated within the walls of a barrier that is non-permeable to air or sealed within the walls of an existing barrier constructed from a material that is non-permeable to air. A functional grading of deliberate design within the walls of the adsorbent material may also be incorporated to further ensure non-permeation of gases.

The water-permeable barrier is highly unique in that it also serves as a "getter" material, or moisture sink, that acts to attract moisture from the product end, the sieve bed valves, and the valve manifold and any dry interconnections. Upon shutdown, the getter material sequesters any moisture remaining in or entering the system.

The moisture management system also serves as a pulse control system and acts as an oxygen reservoir.

In certain embodiments, the use of aluminum as the outer cylinder **27** promotes heat dissipation thereby maintaining maximum adsorption capacity in the sieve bed and aiding in the condensation and attraction of moisture in the feed stream to the water-permeable material.

The outer chamber material is impermeable to both water and gases. The inner chamber material is impermeable to gases yet highly permeable to water.

16

Configuration of the moisture management system within the device has been described with a multiple container arrangement as depicted in FIG. **11** to have a greater impact upon moisture removal, however the device could similarly function with a single container.

Pressure swing adsorption (PSA) devices using zeolites have been used for many different separation applications of gases or liquids including the separation of air to produce medical grade oxygen. Many of these systems use hundreds or thousands of grams of zeolites depending on the application. Hundreds of grams of zeolites are used in two-zeolite-containing-column-separation systems designed to produce oxygen for long-term home applications. Moisture in the compressed air entering these air-separation systems is not typically a problem since one column is being used for air separation while the other is being regenerated and the cycle time between the columns is on the order of minutes.

The portable rapid cycle pressure swing air separation devices of the invention produce medical grade oxygen with a cycle time of approximately one-second between the advanced molecular sieve-containing beds. The unit is specifically designed as a light-weight portable system and uses only about 10 to 20 grams of a zeolite specifically designed for use in this rapid cycle system. Since small quantities of advanced molecular sieve materials (especially zeolites) are used in this system, precautions are utilized to both minimize the amount of moisture permitted to enter the zeolite columns and to protect the molecular sieve material from moisture entering the system from the air entrance port or through the oxygen exit port when the system is not in use.

A method for the simultaneous drying and humidifying of two separate gas streams in a PSA oxygen concentrator is described. Incoming feed air directed into a chamber containing, for example, coaxial tubes, the inner being comprised of a non-porous material with propensities towards water adsorption, surrenders moisture which then migrates through the adsorbent to the outgoing dry gas. Furthermore, the method allows for a moisture sink during periods of non-operation. The prior art contains many references to moisture removal. These techniques include desiccant dryers, membrane filters, centrifugal devices, etc. The moisture management system described is superior to past techniques. It is lightweight, low cost, and self-sustaining (does not need to be replaced during the lifetime of the concentrator). Furthermore, unlike membrane filters, the water-permeable material is impervious to nitrogen and oxygen, thus no undesirable nitrogen may enter the product stream.

In certain embodiments, the process used to minimize the moisture entering the portable oxygen concentrator utilizes a drying/re-moisturizing component located after the air compressor and prior to the adsorbent beds. The drying/re-moisturizing apparatus contains two co-axial container systems (two moisture control unit components **24** shown in FIG. **11** as (A) and (B), for example, as a co-axial tubular design). The containers **24** are sealed near the ends producing an outer chamber **27** and an inner chamber **28**. Each container has an entry port **45** and exit port **46**. The outer container wall is non-permeable to air or moisture with the entry port located near one end of the container and connected to the compressor **2** (not shown in FIG. **11**). The outer chamber wall is fabricated from a lightweight metal, such as aluminum, which also serves to dissipate heat of compression and enhance condensation of moisture within the chamber for both co-axial systems A and B. The moist compressed air is introduced through the entry port of the first co-axial container system (A), passes through the outer container chamber **27**, and leaves through the exit port **46** of the outer chamber. During

17

this passage, moisture is removed from the air stream as discussed below. The compressed air then flows through the outer container of an identical co-axial container system (B) where the moisture content is further reduced and the air then enters the zeolite compartment (C) where it is separated into an oxygen stream and a nitrogen stream.

Function of the moisture permeable membrane is enhanced by two features of operation: a pressure and moisture differential across the material.

An additional barrier to protect against incoming moisture may be incorporated directly into the sieve bed in the form of a guard layer. The guard layer may contain adsorbents with high propensities for moisture uptake similar to those used to form the inner wall of the moisture uptake chambers. The adsorbents may be chemically or physically sequestered within fibrous forms to prohibit a mixing with those adsorbents responsible for oxygen separation.

The walls of the inner chamber 28 of co-axial systems (A) and (B) comprise a getter material, which is non-permeable to air but permeable to moisture and preferably comprises an adsorbent fabricated within the walls of the container. The adsorbent located in the walls of the inner chamber 28 (a "getter" for moisture) can be (1) incorporated within the walls of a container that is non-permeable to air, (2) sealed within the walls of an existing container constructed from a material that is non-permeable to air, and/or (3) a container produced from an extruded adsorbent permeable to moisture but non-permeable to air. The adsorbent may be aluminum oxide, silica gel, or others obvious to those trained in the art. The extruded inner container walls may be of tubular shape or other designs, for example, a star-shaped tube or other designs that maximize the surface area exposed to the moist compressed air. As moist air passes through the outer container it contacts the wall of the inner container. The adsorbent in the inner container wall sequesters moisture from the compressed air. Two factors enhance moisture transfer from the outer container to the inner container in co-axial systems (A) and (B). The first is that the compressed air pressure in the outer chamber 27 is much higher than the pressure in the inner chamber 28. The second is that the oxygen product stream passing through the inner container of co-axial system (A) is dry and is readily re-moisturized and the moisture is carried away with the product stream. The nitrogen stream leaving sieve bed (C) and passing through the inner container of co-axial system (B) has a lower moisture content than the compressed air passing through the outer container of (B) and moisture is carried away with the nitrogen produced. Both of these factors enhance moisture removal from the compressed air and provide a re-moisturized oxygen product for inhalation thereby preventing patient discomfort due to ultra-dry oxygen.

Adsorbents are preferably utilized in the moisture control unit 24. However, membranes may be used for the drying apparatus such as the one described above. However, the membranes can permit passage of some nitrogen through the membrane and dilute the medical grade oxygen product passing through the inner container of co-axial system (A). The moisture control unit may contain bacteria-suppressing materials, such as colloidal silver.

The second co-axial container system (B) not only further reduces the moisture content of the compressed air but also serves as a "moisture getter" for moisture that may enter the portable rapid cycle pressure swing air separation system when it is not in use. By using a co-axial drying system on the advanced molecular sieve bed inlet and outlets, upon shut-down, the device sequesters moisture from any air entering

18

the device through the air stream entrance or from moisture entering the device through the oxygen and nitrogen exit ports.

The second moisture management approach is to make the sieve beds easily replaceable by the user. V-Box Inc. has a belt wearable concentrator that has separate pouches for compressor, sieve beds, and batteries. This makes the sieve beds replaceable, but only as a separate unit and it requires making 8 pneumatic connections, each with a length of tubing that introduces sizeable flow restrictions. As described herein, in one embodiment, sieve bed architecture has been developed that has only three pneumatic connection points, is very simple to replace, and is hermetically sealed until it is inserted into the oxygen concentrator. Rupture plates preferably cover the ports. These plates are pierced automatically when the sieve module is inserted into the concentrator body. A moisture control unit may be attached to the sieve module so that both the adsorbent bed and filter are changed at the same time. In very moist environments, the adsorbent bed may require more frequent changing, but in general it should last for several months. The adsorbent-filter module is as easy to change as the battery pack. The adsorbent bed-filter pack is preferably stored and/or sold housed in a moisture impenetrable pouch or container.

25 Battery Pack for Portable Oxygen Concentrator

Conventional portable oxygen concentrators deal with additional run-time by various methods. For example, the AirSep "Freestyle" unit offers a battery belt ("AirBelt") for additional run-time beyond the internal battery pack. But the belt is worn by the user and attached to the device through a power cord. Respironics ("EverGo") has two battery compartments allowing the user to double their available run-time by inserting one additional battery pack. The battery weight goes up by increments of 1 battery pack (each approximately 1.5 lbs).

U.S. Pat. No. 7,510,601 discloses the use one or more batteries mounted externally on the portable oxygen concentrator. It is common practice for other portable battery operated devices (e.g. cordless drills, saws, etc.) to mount the battery pack externally to the device. For example, U.S. Pat. No. 3,952,239 and U.S. Pat. No. 6,515,451 describe various battery operated tools with interchangeable battery packs. A more flexible approach to battery utilization is used in the various embodiments of the present invention.

A problem with portable oxygen concentrators is the balance between battery weight and available run-time of the unit. This approach is to allow for a flexible battery pack with minimum impact on the size/weight and available space utilized by the ultra rapid cycle portable oxygen concentrator.

In certain embodiments, the battery pack for the ultra rapid cycle portable oxygen concentrator are incorporated as part of device, yet removable, and take up less volume, than a device that has a housing that the battery pack is inserted into. In many embodiments, the general overall volume is less, since no battery compartment is required. Also, since the pack may be mounted outside on the case, the different battery packs may have the same general shape, conforming to the overall device design, but can have different mass or weights that allow for different quantities of battery cells. Without having the constraint of the housing within the device, the battery pack can conform to the overall shape and design of the device, rather than the battery pack appearing to be a separate component mounted to the device.

Allowing for different battery packs gives the user a flexibility of choosing how much run-time vs. weight carried. If the user is going to operate the unit for an extended period when there might be unknown access to battery charging, the

user could opt for the longer run-time, yet heavier battery pack. The lighter pack could be chosen for quick trips or where weight might be more of an issue (such as while exercising). Illustrated below, this embodiment would allow for weight increments of 0.5 pounds or the weight of a grouping of battery cells sufficient to supply the desired voltage.

FIGS. 6A, 6B, and 6C are back, top and bottom views, respectively, of the battery pack configured with 15 cells (8 on top layer, 7 on bottom layer).

FIG. 7 is an exploded perspective view of the 15 cell battery pack 40 with the battery cells 34, protection circuit module (PCM) unit 36, and back plate 37 of the battery pack case 35.

FIGS. 6 and 7 illustrate an embodiment of the battery pack according to the principles of the current invention. The battery pack case 35 may be shaped to conform to the overall exterior style of the device, and may not be housed within the device, but mounted to appear as part of the device. This embodiment shown in FIGS. 6 and 7 utilizes a curved shape that mimics the overall design of the portable oxygen concentrator. The inclusion of the battery pack 40 on the device completes the shape and design of the portable oxygen concentrator 43. Battery cells 24 are arranged within the case 35 to conform to the general curved shape of the case, filling the available area, and secured to the case through tabs 41 above and below the battery cells 34. Space unfilled by batteries (or wiring, connectors or the PCM) can be left open, or filled with foam.

Recessed female connectors for the positive and negative terminals 42 may be on the battery pack 40 illustrated in FIG. 6C, the connectors may be blade style or other quick release connector type.

FIG. 7 shows the arrangement of the battery pack case 35, battery cells 34, a protection circuit module (PCM) 36 is incorporated within the battery pack for over and under charge protection, and the back plate 37, which is where the guide rail can mate with a corresponding channel on the device case.

FIG. 8 is a side view of a portable oxygen concentrator system having a battery pack module 40 and the remainder of the portable oxygen concentrator module 43 where the battery pack handle 38 conforms to the portable oxygen concentrator's handle 39 to make it appear as a contiguous piece. The portable oxygen concentrator module 43 has a first partial handle portion 39. The battery pack module 40 has a second partial handle portion 38. The battery pack module 40 releasably connects to the portable oxygen concentrator module 43. The first partial handle portion of the portable oxygen concentrator module 43 and the second partial handle portion align to form a single integrated handle. The second partial handle portion 38 may be used to attach and remove the battery pack to and from the device.

The battery pack may be fastened to the remainder of the portable oxygen concentrator portion device through a quick release latch and have a guide rail on the mating surface side which aids in aligning the pack while it is mounted onto the portable device (not shown in FIG. 8).

In certain embodiments, the battery pack 40 has the same height, but allows for variation in overall volume, width and depth, and has different quantities of secondary battery cells wired to deliver the same voltage. The varying quantity of battery cells gives the flexibility of more power and run-time (but heavier weight), or less run-time (but lighter weight), while still conforming to the overall shape of the battery pack 40. FIG. 7 illustrates the design that allows for two rows of battery cells.

In certain embodiments, the battery cells may be grouped and wired in series and the groups arranged and wired in

parallel to deliver the necessary voltage and power. For example, an 18.5 V battery pack using rechargeable lithium ion battery cells (2600 mAh 18650 cells) would have five 3.7 V cells wired in series to give 18.5V, 2 or more of these groups wired in parallel together give additional power. The group of five cells has the maximum capacity of 2.6 Amp-hours, wiring additional groups in parallel increases the available power. Two groups would yield 5.2 A-hrs, 3 groups would supply 7.8 A-hrs. A 5 cell series-set weighs approximately 0.5 pounds, two groups would weigh approximately 1 pound, and longer run-time packs would increase in increments of approximately 0.5 pound.

In certain embodiments, the battery cells may be grouped in a series of 3, 4, 5 or more cells to yield the desired voltage. Groups of these cells may be wired together (and to the PCM) in groups of one or more to yield the desired power capacity.

Selection criteria of the battery cells includes lightweight with high energy density, including but not limited to: lithium ion, lithium-polymer, silver-zinc, or other rechargeable battery cells.

Oxygen Sensor for Portable Oxygen Concentrator

Oxygen concentrators typically include a sensor for measuring oxygen purity and a way to alert the patient should purity dip below 85%. Portable oxygen concentrators typically use an electrochemical sensor (also galvanic cell, and micro-fuel cell type sensors). Such sensors provide an electrical voltage signal linear to oxygen purity. The voltage results from a chemical reaction between sensor materials and oxygen passing into the sensor. Somewhat like a battery, over time the signal changes as sensor electrolytes are consumed. This reaction accelerates in high (85%+) oxygen conditions present in portable oxygen concentrators.

Electrochemical advantage/disadvantage. This sensor requires very low power (less than 0.1 watt), needed only for an auxiliary circuit providing signal analysis (comparison with minimum acceptable oxygen level) and LED status display. The signal is linear to oxygen purity. Sensor warm-up is not required. However, the sensor has a short lifetime (a few months to a year from date of manufacture, even when stored), especially in high purity oxygen environment, requires periodic recalibration, and may require periodic replacement. The accuracy is about 2% to 5%.

Home stationary oxygen concentrators have fewer limitations on power consumption and therefore may use a long lifetime zirconium based oxygen sensor. Such sensor technology is a spin-off from the automobile industry. This sensor requires more power due to a heater and operation at 450° C. The output current is non-linear to oxygen purity. For example, the Fujikura FCX-UWC zirconium based sensor is designed for continuous 75% to 95% oxygen purity, output is 8 to 20 micro-amp, with the heater consuming 1.5 watt.

Zirconium advantage/disadvantage. This sensor has a long lifetime (10,000 hours, actual operation), never needs recalibration, and never requires replacement. Accuracy is 1%. However, it requires large power (1.5+ watt), and a long (4.5 minute) warm-up time followed by a (0.5 minute) settling time.

In view of the advantages and disadvantages noted above, a need has arisen for a long lifetime oxygen sensor suitable for portable oxygen concentrators. The zirconium based sensor is a good candidate if only the power consumption could be reduced.

In one embodiment, the zirconium-based oxygen sensor is operated with less power, which permits the sensor to be used in a portable oxygen concentrator of the invention. The method involves intermittent operation and pulse-width

21

modulation of the sensor's heater control. Using these new methods, the average power is reduced to about 10% to about 20% of normal.

The zirconium based oxygen sensor electronic controls are shown in FIG. 9 and timing is shown in FIG. 10. The oxygen sensor conserves power by being turned off when an oxygen reading is not required. Typically, the microcontroller orchestrates a reading at 10 minutes after startup of the concentrator, and after another 30 minutes. Thereafter readings may be taken as infrequently as once each hour.

Each oxygen reading involves several steps carried out over a 5 minute period. This begins with a 4.5 minute warm-up to 450° C., followed by sufficient time for the signal to settle, followed by capture of the reading, and analysis. Heating of the sensor is handled by the microcontroller via a periodically applied pulse width modulation (PWM) signal to the solid state relay. The PWM is varied by frequency and/or duty cycle. The sensor's current output is converted to a voltage signal, amplified, and then input by the microcontroller's comparator. That reading is compared to a voltage set-point representing 85% oxygen purity. When the sensor reading is above set-point then the LED for oxygen purity ok is lighted. In case the oxygen level dips below 85%, the microcontroller firmware alerts the patient by flashing the LED and/or sounding an alarm. In the extreme case of persistent low oxygen levels, the microcontroller can initiate complete shutdown of the concentrator.

The above described method translates to an average power consumption of 0.2 watts for the zirconium based oxygen sensor compared with 2 watts for continuous operation. This value assumes 5 minutes operation each hour (that is, 5 min/60 min×2 watt=0.2 watt on average). This is an acceptable power level for the oxygen sensor, because the rest of the concentrator, depending upon oxygen setting, requires about 20 watts to about 50 watts.

Optional Features of Portable Oxygen Concentrator

The device may also comprise:

- a source of a fluid mixture comprising at least a first component and a second component;
- a collector of said first component;
- a collector of an exhaust fluid stream enriched in said second component and depleted in said first component;
- an fluid induction unit.
- a data collection component;
- a user interface component; and/or
- a vacuum unit.

The sorption device may further comprise valves, including mechanical check valves, Tesla valves, and pneumatic diode valves, although additional valves are not preferred.

Docking Station

In an alternate embodiment, the portable oxygen concentrator may be part of a system where the portable oxygen concentrator may be removed by the user (for example, when a stationary unit is available or when supplemental oxygen is not needed) and placed in a docking station with a battery recharge to recharge the battery cell(s).

The methods, devices, and systems of the invention may be microprocessor controlled. The adsorption devices of the invention may comprise at least one power conditioning device. Suitable power conditioning devices include a voltage changing device (such as a piezoelectric transformer or a high frequency transformer), a poly-phase frequency generator, a poly-phase frequency amplifier (a power transistor, a complementary metal oxide semiconductor (CMOS), an insulated gate bipolar transistor (IGBT)), or a combination thereof.

Since the devices and systems of the invention are used for concentrating oxygen for medical use, the devices and sys-

22

tems may preferably be small enough in size and weight to be easily carried by an elderly person or an individual with compromised health. The devices or systems may be supported by a purse-like or "fanny pack"-type holder with a shoulder strap.

When used for supplying medical oxygen, the device may further comprise a muffler to dampen noise, an optional cannula, and/or an optional conserver. The cannula may be held by, contained in, or hidden by the shoulder strap described above. The conserver that may be used preferably senses inspiration and either opens a valve admitting oxygen to the cannula, or the sensor controls the cycle time of the portable oxygen concentrator.

It will be apparent to those skilled in the art that various modifications and variations can be made in the present invention and specific examples provided herein without departing from the spirit or scope of the invention. Thus, it is intended that the present invention cover the modifications and variations of this invention that come within the scope of any claims and their equivalents.

EXAMPLES

The present invention is further defined in the following Examples, in which all parts and percentages are by weight and degrees are Celsius, unless otherwise stated. It should be understood that these examples, while indicating preferred embodiments of the invention, are given by way of illustration only. From the above discussion and these examples, one skilled in the art can ascertain the essential characteristics of this invention, and without departing from the spirit and scope thereof, can make various changes and modifications of the invention to adapt it to various usages and conditions.

Example 1

Performance of regenerated adsorbent output of oxygen at high levels of relative humidity (at 75% relative humidity) was measured. The data is shown in FIG. 13. As can be seen in FIG. 13, at 75% relative humidity for input air, oxygen production remains above an 88% purity level for a period of 22 days of continual operation (equivalent to approximately 65 patient operation days). No moisture removal technology was incorporated into the testing regime in order to obtain a baseline of adsorbent performance.

Example 2

Cycle Time Selection for Adsorbent Bed

Tests were conducted using an 18 mm diameter, 76 mm long adsorbent bed that holds approximately 12 grams of the advanced adsorbent. The goal of these tests was to determine the cycle time that leads to the highest possible efficiency. In order to do this, the flow rate of air into the bed and the flow rate of the oxygen-enriched product out of the bed were measured, in order to calculate the productivity (also known as recovery rate) of the bed. Productivity is calculated as follows:

$$P = \frac{Q_{\text{oxygen}} \times \text{O}_2 \text{ Purity}}{Q_{\text{air}} \times 0.209}$$

Where P is productivity, Q_{oxygen} is the flow rate of oxygen, $\text{O}_2 \text{ Purity}$ is the decimal purity of Oxygen, and Q_{air} is the flow

23

rate of air, which is multiplied by 0.209 (the nominal oxygen purity of atmospheric air) to obtain the amount of oxygen in the air that passed through the bed. In this case, a cycle of 0.78 seconds duration produces 0.8 LPM of high purity (95% for the duration of the test) oxygen, while requiring approximately 10 LPM of air input. This meets the requirements set out for the portable medical oxygen concentrator of the invention. The results are shown in FIG. 14.

Example 3

Adsorbent Bed Dimensions (Length/Diameter Ratio) and Quantity of Adsorbent

Several different sizes of adsorbent bed were tested to determine the proper dimensions for a bed to be used with the advanced adsorbent.

Length (mm)	Diameter (mm)	L/D ratio	Mass Ads (g)	Max Output (LPM)
76	16	4.75	9.2	0.6#
101	16	6.31	12.2	0.74*
114	16	7.125	13.8	0.8*
76	18	4.22	11.6	0.8^

*= requires a pressure input of 270 kPa absolute

^= requires a pressure input of 225 kPa absolute

#= requires a pressure input of 250 kPa absolute

From the results of the tests, it can be shown that an L/D ratio of 4.22 worked the best in terms of energy efficiency because it requires less pressure to produce adequate output.

An additional consideration that affects the size of the adsorbent bed is the amount of time it is able to operate until it must be replaced because the performance has degraded due to water adsorption. It is possible to use 4 adsorbent beds that hold less than one gram of adsorbent, cycle them at 3-4 cycles per second, and produce the targeted output of 0.75 LPM of 85%+ oxygen, but they last for less than one day before they must either be replaced or regenerated by heating them and passing a dry purge gas through them to carry away the water that is liberated. FIGS. 15 and 16 show the degradation curves (at 60% relative humidity) for one adsorbent bed that holds less than one gram of adsorbent (FIG. 15), and for one adsorbent bed that holds approximately 10 grams of adsorbent (FIG. 16).

Example 4

Maximum Cycle Rates

The maximum possible cycles rates while still achieving at least 85% purity of oxygen were determined using the advanced adsorbents employed in the invention. The results are shown in FIG. 17. A plot showing the maximum cycle rate (in Hz) as a function of adsorbent mass (in grams) achieving at least 85% oxygen purity is presented in FIG. 17.

Example 5

Gas Flow

Function of the moisture permeable membrane is enhanced by two features of operation: a pressure and moisture differential across the material. To demonstrate the transfer of moisture from a moist air stream to a dry oxygen flow under these conditions, tests were performed. Using a container

24

prepared with non-optimized adsorbent walls, moist air with relative humidity (RH) of 60% was introduced into the outer container as ultra-dry oxygen (RH=<0.1%) was concurrently flowed through the inner chamber. A pressure differential of 10 psi was maintained throughout the experiment along with a ten-fold decrease in flow between the moist and dry gas streams. After equilibrium was achieved, RH of the moist air decreased by 32% while the moisture level of the dry oxygen increased to 7%. The purity level of oxygen was unaltered during the experiment thereby confirming the impervious nature of the adsorbent material to gases.

When ranges are used herein for physical properties, such as molecular weight, or chemical properties, such as chemical formulae, all combinations, and subcombinations of ranges specific embodiments therein are intended to be included.

The disclosures of each patent, patent application and publication cited or described in this document are hereby incorporated herein by reference, in its entirety.

Those skilled in the art will appreciate that numerous changes and modifications can be made to the preferred embodiments of the invention and that such changes and modifications can be made without departing from the spirit of the invention. It is, therefore, intended that the appended claims cover all such equivalent variations as fall within the true spirit and scope of the invention.

What is claimed is:

1. A portable oxygen concentrator system, comprising:
 - a housing;
 - at least one removable adsorbent cartridge;
 - a compressor;
 - a manifold to control as flow into and out of said removable module;
 - a removable battery pack;
 - wherein said battery pack is capable of accommodating a variable number of battery cells without changing the shape of said portable oxygen concentrator system; and
 - wherein said battery pack is external to said housing and conforms to and completes the overall shape of said portable oxygen concentrator system
- wherein said at least one removable adsorbent cartridge comprises:
 - at least one adsorbent bed;
 - wherein said adsorbent bed comprises at least one molecular sieve material;
 - wherein said molecular sieve material has a substantially spherical shape;
 - wherein the ratio of the length of said adsorbent bed to the diameter of said adsorbent bed is less than about 4.8:1; and
 - wherein said adsorbent bed is capable of a ratio of product flow rate to mass of said molecular sieve material of greater than 3.3 ml/min/g.
2. A portable oxygen concentrator system of claim 1, further comprising:
 - at least one battery cell.
3. A portable oxygen concentrator system of claim 1, wherein said battery pack comprises:
 - a battery pack case;
 - a plurality of tabs for securing said battery cells in said battery.
4. A portable oxygen concentrator system of claim 3, wherein said battery pack case, further comprises:
 - a back plate.

25

5. A portable oxygen concentrator system of claim 3, wherein said battery pack case, further comprises:
a protection circuit module unit.
6. A portable oxygen concentrator system of claim 1, further comprising:
a moisture control unit.
7. A portable oxygen concentrator system of claim 1, further comprising:
an oxygen sensor.
8. A portable oxygen concentrator system of claim 1, further comprising:
a muffler connected to said manifold.
9. A portable oxygen concentrator system of claim 1, further comprising:
a cannula.
10. A portable oxygen concentrator system of claim 1, further comprising:
a conserver.
11. A portable oxygen concentrator system of claim 1, further comprising:
a docking station; and
a battery recharger.
12. A portable oxygen concentrator system, comprising:
at least one removable module comprising
a housing;
at least one adsorbent bed contained in said housing;
wherein said adsorbent bed comprises at least one
molecular sieve material;
wherein said molecular sieve material has a substantially
spherical shape;
wherein the ratio of the length of said adsorbent bed to
the diameter of said adsorbent bed is less than about
4.8:1; and

26

- wherein said adsorbent is capable of a ratio of product
flow rate to mass of said molecular sieve material of
greater than 3.3 ml/min/g;
a compressor;
a manifold to control gas flow into and out of said removable module; and
at least one removable battery pack;
wherein said portable oxygen concentrator system weighs
less than about 5 kg.
13. A portable oxygen concentrator system of claim 12, wherein said at least one removable module comprises one adsorbent bed.
14. A portable oxygen concentrator system of claim 12, wherein said at least one removable module comprises two adsorbent beds.
15. A portable oxygen concentrator system of claim 12, wherein said molecular sieve material has a mass less than about 50 g.
16. A portable oxygen concentrator system of claim 12, wherein said molecular sieve material comprises zeolite.
17. A portable oxygen concentrator system of claim 12, wherein said molecular sieve material comprises a metal-exchanged zeolite.
18. A portable oxygen concentrator system of claim 12, wherein said metal-exchanged zeolite is Li⁺-exchanged zeolite.
19. A portable oxygen concentrator system of claim 12, wherein said adsorbent bed has a length of no greater than about 12 cm.
20. A portable oxygen concentrator system of claim 12, wherein said adsorbent bed has a diameter of no greater than about 2.5 cm.
21. A portable oxygen concentrator system of claim 12, wherein said removable module is replaceable by a user.

* * * * *